

KumhoSunny PC/PBT HCB9320G

Polycarbonate + PBT

Shanghai KumhoSunny Plastics Co., Ltd.

Message:

HCB9320G is a 20% glass fiber reforced PC/PBT alloy resin, offering high heat resistance, high mechanical strength and excellent chemical resistance. HCB9320G is recommended for automobile luggage carrier, household appliance, electrician products, etc.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Good Chemical Resistance		
	High Heat Resistance		
Uses	Automotive Applications		
	Electrical Parts		
	Electrical/Electronic Applications		
	Household Goods		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.42	g/cm ³	ASTM D792
--	1.35	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
250°C/5.0 kg	18	g/10 min	ASTM D1238
250°C/5.0 kg	16	g/10 min	ISO 1133
Molding Shrinkage			
Flow	0.40 to 0.60	%	ASTM D955
--	0.40 to 0.60	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
--	100	MPa	ASTM D638
--	105	MPa	ISO 527-2/5
Tensile Elongation (Break)	4.0	%	ASTM D638
Flexural Modulus			
--	5200	MPa	ASTM D790
-- ¹	5500	MPa	ISO 178

Flexural Strength			
--	140	MPa	ASTM D790
-- ²	145	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	kJ/m ²	ISO 179
Notched Izod Impact			
3.20 mm	110	J/m	ASTM D256
23°C	11	kJ/m ²	ISO 180
Unnotched Izod Impact Strength (23°C)	70	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	125	°C	ASTM D648
1.8 MPa, Unannealed ³	130	°C	ISO 75-2/A
Vicat Softening Temperature	150	°C	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+15	ohms	IEC 60093
Volume Resistivity	> 1.0E+15	ohms·cm	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	230 to 260	°C	
Middle Temperature	240 to 275	°C	
Front Temperature	240 to 275	°C	
Nozzle Temperature	245 to 270	°C	
Processing (Melt) Temp	240 to 275	°C	
Mold Temperature	50.0 to 80.0	°C	
Back Pressure	0.300 to 1.00	MPa	
Screw Speed	30 to 70	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	120°C/h		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

