

KumhoSunny ABS HU650SK-P

Acrylonitrile Butadiene Styrene
Shanghai KumhoSunny Plastics Co., Ltd.

Message:
ABSHU650SK-P is super high heat resistance ABS resin for plating , offering high rigidity and high impact.

General Information			
Features	High Heat Resistance		
	High Impact Resistance		
	High Rigidity		
UL File Number	E254819		
	E65424		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.06	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	4.0	g/10 min	ISO 1133
Molding Shrinkage (23°C)	0.40 to 0.70	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress	40.0	MPa	ISO 527-2/50
Tensile Strain (Break)	65	%	ISO 527-2/50
Flexural Modulus ¹ (64.0 mm)	2360	MPa	ISO 178
Flexural Stress ² (64.0 mm)	65.0	MPa	ISO 178
Poisson's Ratio	0.39		ISO 527
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ³			ISO 179
-30°C	11	kJ/m ²	
23°C	22	kJ/m ²	
Charpy Unnotched Impact Strength ⁴			ISO 179
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ⁵			ISO 180
-30°C	10	kJ/m ²	
23°C	20	kJ/m ²	
Unnotched Izod Impact Strength ⁶			ISO 180
-30°C	No Break		
23°C	No Break		

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed	111	°C	ISO 75-2/B
1.8 MPa, Unannealed	95.0	°C	ISO 75-2/A
Vicat Softening Temperature	115	°C	ISO 306/B50
CLTE			ISO 11359-2
Flow : -40 to 40°C	7.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.6E-5	cm/cm/°C	
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	90.0 to 105	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	220 to 230	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	260 to 270	°C	
Nozzle Temperature	250 to 260	°C	
Processing (Melt) Temp	250 to 260	°C	
Mold Temperature	50.0 to 80.0	°C	
Back Pressure	1.00 to 5.00	MPa	
Screw Speed	30 to 70	rpm	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	Condition: 4 J		
4.	Condition: 4 J		
5.	Condition: 5.5 J		
6.	Condition: 5.5 J		
7.	120°C/h		

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