

**HAC5010G**

(PC+ABS)-GF

Shanghai Kumho Sunny Plastics Co., Ltd.

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	10	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Strength	65	MPa	ISO 527
Flexural modulus, 23°C	3500	MPa	ISO 178
Flexural strength	110	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	9	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Strength	70	MPa	ASTM D 638
Elongation at Break	5	%	ASTM D 638
Flexural Modulus	4000	MPa	ASTM D 790
Flexural Strength	110	MPa	ASTM D 790
Izod Impact notched, 1/8 in	130	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	112	°C	ISO 75-1/-2
Vicat softening temperature, B	120	°C	ISO 306
<b>ASTM Data</b>			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	110	°C	ASTM D 648
Vicat Temperature	122	°C	ASTM D 1525
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
<b>Other properties</b>			
Density	1190	kg/m <sup>3</sup>	ISO 1183
Density	1200	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	260 - 270	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	220 - 240	°C	-
Zone 2	240 - 260	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	250 - 260	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	0.3 - 1	MPa	-

**Characteristics**

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**Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Applications**

Electrical and Electronical