

HAC8250TC

(PC+ABS)-MX

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
ASTM Data			
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
Mechanical properties			
ISO Data			
Tensile Strength	52	MPa	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy notched impact strength, +23°C	30	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	25	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength	55	MPa	ASTM D 638
Elongation at Break	30	%	ASTM D 638
Flexural Modulus	2700	MPa	ASTM D 790
Flexural Strength	80	MPa	ASTM D 790
Izod Impact notched, 1/8 in	400	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	103	°C	ISO 75-1/-2
Vicat softening temperature, B	115	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	100	°C	ASTM D 648
Vicat Temperature	115	°C	ASTM D 1525
Electrical properties			
ISO Data			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Other properties			
Value			
Density	1180	kg/m ³	ISO 1183
Density	1180	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value			
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	230 - 250	°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

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Regional Availability

Asia Pacific

Applications

Automotive