

**HAP8920**  
(PA66+PPE)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	70	g/10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
Molding shrinkage, parallel	1.3	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Strength	63	MPa	ISO 527
Strain at break	80	%	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	9.7	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	24.8	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	17.9	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	7.9	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	175	°C	ISO 75-1/-2
Vicat softening temperature, B	190	°C	ISO 306
Coeff. of linear therm. expansion, parallel	90	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	12.6	E-6/K	ISO 11359-1/-2

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	1E15	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	1100	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	99 - 105	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	280 - 305	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	260 - 300	°C	-
Zone 2	270 - 300	°C	-
Zone 3	275 - 300	°C	-
Nozzle temperature	280 - 230	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	1 - 5	MPa	-

**Characteristics****Processing**  
Injection Molding**Regional Availability**  
Asia Pacific