

HCG2510FR

PC

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.004	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Strength	60	MPa	ASTM D 638
Elongation at Break	10	%	ASTM D 638
Flexural Modulus	3500	MPa	ASTM D 790
Flexural Strength	110	MPa	ASTM D 790
Izod Impact notched, 1/8 in	140	J/m	ASTM D 256
Thermal properties			
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	142	°C	ASTM D 648
Electrical properties			
ISO Data			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Other properties			
Density	1270	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 290	°C	-
Mold temperature	60 - 100	°C	-
Zone 1	240 - 260	°C	-
Zone 2	265 - 275	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	275 - 285	°C	-
Screw speed	20 - 80	rpm	-
Back pressure	0.2 - 0.8	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

Asia Pacific

Applications

Electrical and Electronical