

HAC-M
(PC+ABS)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	50	g/10min	ASTM D 1238
Temperature	260	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.005	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	60	MPa	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	78	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact unnotched, 1/8 in	200	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	85	°C	ASTM D 648
Vicat Temperature	95	°C	ASTM D 1525

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

Optical properties	Value	Unit	Test Standard
Other Standards^[5]			
Gloss	90	-	ASTM D523

S: These properties are reported by the producer according standards that are different to our defaults.

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90 - 110	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.03	%	-
Melt temperature	240 - 250	°C	-
Mold temperature	85 - 95	°C	-
Zone 1	210 - 240	°C	-
Zone 2	220 - 245	°C	-
Zone 3	230 - 255	°C	-
Nozzle temperature	230 - 250	°C	-
Screw speed	40 - 55	rpm	-
Back pressure	0.3 - 1	MPa	-

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