

HSP8344

(PS+PPE)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	10	g/10min	ISO 1133
Temperature	280	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	12	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	45	MPa	ISO 527
Strain at break	82	%	ISO 527
Flexural modulus, 23°C	1920	MPa	ISO 178
Flexural strength	59	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	20.4	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	37.8	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	35.6	kJ/m ²	ISO 180/1A
Izod notched impact strength	17.6	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
ASTM Data			
Tensile Strength	43	MPa	ASTM D 638
Elongation at Break	70	%	ASTM D 638
Flexural Modulus	1820	MPa	ASTM D 790
Flexural Strength	60	MPa	ASTM D 790
Izod Impact notched, 1/8 in	510	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	120	°C	ISO 75-1/-2
Vicat softening temperature, B	122	°C	ISO 306
Coeff. of linear therm. expansion, parallel	66	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	76	E-6/K	ISO 11359-1/-2
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	113	°C	ASTM D 648
Vicat Temperature	120	°C	ASTM D 1525
Electrical properties			
ISO Data			
Surface resistivity	1E16	Ohm	IEC 62631-3-2
Other properties			
Density	1050	kg/m ³	ISO 1183
Density	1040	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	70 - 90	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-

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Melt temperature	260	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	230 - 250	°C	-
Zone 2	250 - 270	°C	-
Zone 3	255 - 275	°C	-
Nozzle temperature	260 - 275	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	1 - 5	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Special Characteristics

High impact or impact modified

Regional Availability

Asia Pacific