

HFA705

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	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Strength	43	MPa	ASTM D 638
Elongation at Break	15	%	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	55	MPa	ASTM D 790
Izod Impact notched, 1/8 in	200	J/m	ASTM D 256
Thermal properties			
ASTM Data			
UL 94 Flame rating	V-1	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 264 psi	80	°C	ASTM D 648
Vicat Temperature	93	°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
Processing Recommendation Injection Molding			
Pre-drying - Temperature	80 - 90	°C	-
Pre-drying - Time	2 - 3	h	-
Processing humidity	≤0.05	%	-
Melt temperature	200 - 220	°C	-
Mold temperature	40 - 80	°C	-
Zone 1	180 - 190	°C	-
Zone 2	190 - 200	°C	-
Zone 3	195 - 205	°C	-
Nozzle temperature	195 - 205	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	1 - 5	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Electrical and Electronical

Special Characteristics

Flame retardant, U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Regional Availability

Asia Pacific

Features

Color Stability