

HGX4300

ABS

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	4	g/10min	ASTM D 1238
Temperature	220	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	45	MPa	ASTM D 638
Elongation at Break	14	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	65	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	90	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	40	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	108	°C	ASTM D 648
Vicat Temperature	116	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	1070	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 85	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	240 - 260	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	190 - 220	°C	-
Zone 2	220 - 240	°C	-
Zone 3	230 - 250	°C	-
Nozzle temperature	240 - 260	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

Asia Pacific

Special Characteristics

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