

**HGX4400**

ABS

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>3</b>	g/10min	ASTM D 1238
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
Mold Shrinkage, MD	<b>0.0055</b>	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength	<b>46</b>	MPa	ASTM D 638
Elongation at Break	<b>10</b>	%	ASTM D 638
Flexural Modulus	<b>2200</b>	MPa	ASTM D 790
Flexural Strength	<b>62</b>	MPa	ASTM D 790
Izod Impact notched, 1/8 in	<b>140</b>	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
DTUL @ 264 psi	<b>110</b>	°C	ASTM D 648
Vicat Temperature	<b>120</b>	°C	ASTM D 1525

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Volume resistivity	<b>1E14</b>	Ohm*m	IEC 62631-3-1
Surface resistivity	<b>1E14</b>	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	<b>1070</b>	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>80 - 95</b>	°C	-
Pre-drying - Time	<b>3 - 4</b>	h	-
Processing humidity	<b>≤0.05</b>	%	-
Melt temperature	<b>240 - 260</b>	°C	-
Mold temperature	<b>50 - 80</b>	°C	-
Zone 1	<b>220 - 240</b>	°C	-
Zone 2	<b>230 - 250</b>	°C	-
Zone 3	<b>240 - 260</b>	°C	-
Nozzle temperature	<b>250 - 270</b>	°C	-
Screw speed	<b>30 - 70</b>	rpm	-
Back pressure	<b>1 - 5</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific

**Special Characteristics**

Heat stabilized or stable to heat