

HGX4500

ABS

Shanghai Kumho Sunny Plastics Co., Ltd.

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

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	46	MPa	ASTM D 638
Elongation at Break	10	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	64	MPa	ASTM D 790
Izod Impact notched, 1/8 in	130	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
DTUL @ 264 psi	115	°C	ASTM D 648
Vicat Temperature	125	°C	ASTM D 1525

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

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 - 95	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	240 - 260	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	220 - 240	°C	-
Zone 2	230 - 250	°C	-
Zone 3	240 - 260	°C	-
Nozzle temperature	250 - 270	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	1 - 5	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

Asia Pacific

Special Characteristics

Heat stabilized or stable to heat