

HU621

ABS

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	6	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Strength	42	MPa	ISO 527
Strain at break	20	%	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	60	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	25	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	14	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	24	kJ/m ²	ISO 180/1A
Izod notched impact strength	13	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 105	-	ISO 2039-2

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	83	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	94	°C	ISO 75-1/-2
Vicat softening temperature, B	102	°C	ISO 306
ASTM Data			
UL 94 Flame rating	HB	-	UL 94

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	1060	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	85 - 95	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	230 - 250	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	190 - 210	°C	-
Zone 2	210 - 220	°C	-
Zone 3	220 - 235	°C	-
Nozzle temperature	230 - 245	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	1 - 5	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

Asia Pacific

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather, Heat stabilized or stable to heat