

**HEB4051M**

(PBT+PET)-MX

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	15	g/10min	ISO 1133
Temperature	265	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	1.0	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Strength	45	MPa	ISO 527
Flexural modulus, 23°C	4000	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy notched impact strength, +23°C	5.5	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	3.5	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 0.45 MPa	200	°C	ISO 75-1/-2

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

Other properties	Value	Unit	Test Standard
Density	1500	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	245 - 265	°C	-
Mold temperature	70 - 80	°C	-
Zone 1	230 - 240	°C	-
Zone 2	240 - 250	°C	-
Zone 3	250 - 255	°C	-
Nozzle temperature	255 - 265	°C	-
Screw speed	20 - 100	rpm	-
Back pressure	0.2 - 0.8	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Asia Pacific