

HAC8244H

(PC+ABS)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	45	MPa	ISO 527
Flexural modulus, 23°C	1950	MPa	ISO 178
Flexural strength	64	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	45	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	30	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	95	°C	ISO 75-1/-2
Vicat softening temperature, B	110	°C	ISO 306
Burning rate, FMVSS, Thickness 1 mm	80	mm/min	ISO 3795 (FMVSS 302)
Other Standards^[S]			
Coefficient of Thermal Expansion, MD	88.2	E-6/K	ASTM E 831
Coefficient of Thermal Expansion, TD	91.8	E-6/K	ASTM E 831

S: These properties are reported by the producer according standards that are different to our defaults.

Other properties	Value	Unit	Test Standard
Density	1100	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	95 - 105	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 100	°C	-
Zone 1	230 - 260	°C	-
Zone 2	240 - 275	°C	-
Zone 3	245 - 280	°C	-
Nozzle temperature	245 - 280	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

Asia Pacific