

HAC8250

(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 Strength	55	MPa	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	72	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	52	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	32	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	50	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	105	°C	ISO 75-1/-2
Vicat softening temperature, B	122	°C	ISO 306

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	1130	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	60 - 80	°C	-
Zone 1	220 - 230	°C	-
Zone 2	240 - 250	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	250 - 260	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	0.3 - 1	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Applications

Automotive

Regional Availability

Asia Pacific