

HEG3615

PET-GF15

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	40	g/10min	ISO 1133
Temperature	265	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.008	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	85	MPa	ISO 527
Flexural modulus, 23°C	4000	MPa	ISO 178
Flexural strength	130	MPa	ISO 178
Charpy notched impact strength, +23°C	7.5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	5	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	7	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength	120	MPa	ASTM D 638
Elongation at Break	2	%	ASTM D 638
Flexural Modulus	9500	MPa	ASTM D 790
Flexural Strength	185	MPa	ASTM D 790
Izod Impact notched, 1/8 in	80	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	180	°C	ISO 75-1/-2
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.6	mm	-
DTUL @ 66 psi	245	°C	ASTM D 648
DTUL @ 264 psi	220	°C	ASTM D 648
Electrical properties			
ISO Data			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Other properties			
Density	1400	kg/m ³	ISO 1183
Density	1550	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	120 - 140	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	245 - 275	°C	-
Mold temperature	100 - 120	°C	-
Zone 1	245 - 260	°C	-
Zone 2	250 - 265	°C	-
Zone 3	255 - 270	°C	-
Nozzle temperature	260 - 275	°C	-
Screw speed	20 - 100	rpm	-
Back pressure	0.2 - 0.8	MPa	-

Characteristics

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Processing

Injection Molding

Special Characteristics

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

Features

Fatigue Resistance

Applications

Automotive, Electrical and Electronical

Regional Availability

Asia Pacific