

HEC0245

(PC+AEPDS)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	20	g/10min	ASTM D 1238
Temperature	230	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	50	MPa	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	63	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	48	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	32	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	45	kJ/m ²	ISO 180/1U
ASTM Data			
Tensile Strength	53	MPa	ASTM D 638
Elongation at Break	60	%	ASTM D 638
Flexural Modulus	1900	MPa	ASTM D 790
Flexural Strength	70	MPa	ASTM D 790
Izod Impact notched, 1/8 in	500	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	96	°C	ISO 75-1/-2
Vicat softening temperature, B	110	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	100	°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	1120	kg/m ³	ISO 1183
Density	1080	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 260	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	220 - 230	°C	-
Zone 2	230 - 240	°C	-
Zone 3	250 - 260	°C	-
Nozzle temperature	240 - 250	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	0.3 - 1	MPa	-

Characteristics

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Processing

Injection Molding

Applications

Automotive

Special Characteristics

Flame retardant, Halogen-free, Heat stabilized or stable to heat

Regional Availability

Asia Pacific