

HEC0275

(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	13	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	58	MPa	ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	50	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	48	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength	60	MPa	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	80	MPa	ASTM D 790
Izod Impact notched, 1/8 in	700	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	108	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 264 psi	110	°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	1150	kg/m ³	ISO 1183
Density	1150	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	100 - 110	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	220 - 240	°C	-
Zone 2	240 - 260	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	250 - 260	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	0.3 - 1	MPa	-

Characteristics

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Processing

Injection Molding

Regional Availability

Asia Pacific

Special Characteristics

Heat stabilized or stable to heat