

HCB9230

(PC+PBT)

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	15	g/10min	ISO 1133
Temperature	250	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.8	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	13	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.0075	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	56	MPa	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy impact strength, +23°C	N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	55	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	30	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	55	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength	63	MPa	ASTM D 638
Elongation at Break	120	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	87	MPa	ASTM D 790
Izod Impact notched, 1/8 in	820	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	98	°C	ISO 75-1/-2
Vicat softening temperature, B	115	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	107	°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	1200	kg/m ³	ISO 1183
Density	1200	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	240 - 270	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	230 - 260	°C	-
Zone 2	240 - 270	°C	-
Zone 3	240 - 270	°C	-
Nozzle temperature	245 - 265	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	0.3 - 1	MPa	-

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Characteristics**Processing**

Injection Molding

Applications

Automotive, Electrical and Electronical

Special Characteristics

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

Regional Availability

Asia Pacific

Chemical Resistance

General Chemical Resistance