

HCB9310G

(PC+PBT)-GF10

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	18	g/10min	ISO 1133
Temperature	250	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	18	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	5	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	82	MPa	ISO 527
Flexural modulus, 23°C	4100	MPa	ISO 178
Flexural strength	120	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	70	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	9	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength	82	MPa	ASTM D 638
Elongation at Break	4	%	ASTM D 638
Flexural Modulus	4000	MPa	ASTM D 790
Flexural Strength	125	MPa	ASTM D 790
Izod Impact notched, 1/8 in	100	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
Vicat softening temperature, B	128	°C	ISO 306
Electrical properties			
ISO Data			
Volume resistivity	1E15	Ohm*m	IEC 62631-3-1
Surface resistivity	>1E15	Ohm	IEC 62631-3-2
Other properties			
Density	1290	kg/m ³	ISO 1183
Density	1290	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 275	°C	-
Mold temperature	50 - 80	°C	-
Zone 1	230 - 260	°C	-
Zone 2	240 - 275	°C	-
Zone 3	240 - 275	°C	-
Nozzle temperature	245 - 270	°C	-
Screw speed	30 - 70	rpm	-
Back pressure	0.3 - 1	MPa	-

Characteristics

HCB9310G

(PC+PBT)-GF10

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing

Injection Molding

Applications

Automotive, Electrical and Electronical

Special Characteristics

Heat stabilized or stable to heat

Regional Availability

Asia Pacific

Chemical Resistance

General Chemical Resistance