

HCB9320G

(PC+PBT)-GF20

Shanghai Kumho Sunny Plastics Co., Ltd.

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	16	g/10min	ISO 1133
Temperature	250	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.5	%	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	0.005	mm/mm	ASTM D 955
Mechanical properties			
ISO Data			
Tensile Strength	105	MPa	ISO 527
Flexural modulus, 23°C	5500	MPa	ISO 178
Flexural strength	145	MPa	ISO 178
Charpy notched impact strength, +23°C	13	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	70	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	11	kJ/m ²	ISO 180/1A
ASTM Data			
Tensile Strength	100	MPa	ASTM D 638
Elongation at Break	4	%	ASTM D 638
Flexural Modulus	5200	MPa	ASTM D 790
Flexural Strength	140	MPa	ASTM D 790
Izod Impact notched, 1/8 in	110	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	130	°C	ISO 75-1/-2
Vicat softening temperature, B	150	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	125	°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	1350	kg/m ³	ISO 1183
Density	1420	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	-

HCB9320G

(PC+PBT)-GF20

Shanghai Kumho Sunny Plastics Co., Ltd.

Characteristics**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