

**C-Clear™ K8272**

(PC+ABS)

Shanghai Kumho Sunny Plastics Co., Ltd.

| <b>Processing/Physical Characteristics</b>         | <b>Value</b>     | <b>Unit</b>       | <b>Test Standard</b> |
|--|------------------|-------------------|----------------------|
| <b>ISO Data</b>                                    |                  |                   |                      |
| Molding shrinkage, parallel                        | <b>0.6</b>       | %                 | ISO 294-4, 2577      |
| <b>Mechanical properties</b>                       |                  |                   |                      |
| <b>ISO Data</b>                                    |                  |                   |                      |
| Tensile Strength                                   | <b>76</b>        | MPa               | ISO 527              |
| Flexural modulus, 23°C                             | <b>2300</b>      | MPa               | ISO 178              |
| Flexural strength                                  | <b>76</b>        | MPa               | ISO 178              |
| Charpy impact strength, +23°C                      | <b>N</b>         | kJ/m <sup>2</sup> | ISO 179/1eU          |
| Charpy notched impact strength, +23°C              | <b>55</b>        | kJ/m <sup>2</sup> | ISO 179/1eA          |
| Charpy notched impact strength, -30°C              | <b>35</b>        | kJ/m <sup>2</sup> | ISO 179/1eA          |
| Izod notched impact strength, +23°C                | <b>52</b>        | kJ/m <sup>2</sup> | ISO 180/1A           |
| <b>Thermal properties</b>                          |                  |                   |                      |
| <b>ISO Data</b>                                    |                  |                   |                      |
| Temp. of deflection under load, 1.80 MPa           | <b>110</b>       | °C                | ISO 75-1/-2          |
| Vicat softening temperature, B                     | <b>126</b>       | °C                | ISO 306              |
| <b>Electrical properties</b>                       |                  |                   |                      |
| <b>ISO Data</b>                                    |                  |                   |                      |
| Volume resistivity                                 | <b>1E15</b>      | Ohm*m             | IEC 62631-3-1        |
| Surface resistivity                                | <b>&gt;1E15</b>  | Ohm               | IEC 62631-3-2        |
| <b>Other properties</b>                            |                  |                   |                      |
| Density  | <b>1140</b>      | kg/m <sup>3</sup> | ISO 1183             |
| <b>Processing Recommendation Injection Molding</b> |                  |                   |                      |
| Pre-drying - Temperature                           | <b>100 - 110</b> | °C                | -                    |
| Pre-drying - Time                                  | <b>4 - 6</b>     | h                 | -                    |
| Processing humidity                                | <b>≤0.02</b>     | %                 | -                    |
| Melt temperature                                   | <b>250 - 270</b> | °C                | -                    |
| Mold temperature                                   | <b>60 - 80</b>   | °C                | -                    |
| Zone 1   | <b>220 - 230</b> | °C                | -                    |
| Zone 2   | <b>240 - 250</b> | °C                | -                    |
| Zone 3   | <b>260 - 270</b> | °C                | -                    |
| Nozzle temperature                                 | <b>250 - 260</b> | °C                | -                    |
| Screw speed  | <b>30 - 70</b>   | rpm               | -                    |
| Back pressure                                      | <b>0.3 - 1</b>   | MPa               | -                    |

**Characteristics****Processing**

Injection Molding

**Applications**

Automotive

**Special Characteristics**

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

**Regional Availability**

Asia Pacific