

Technical Data Sheet

HAC8260-G

PC/ABS

PRODUCT DESCRIPTION:

PC/ABS HAC8260-G is a high gloss and heat resistance PC/ABS resin.

FEATURES:

- High gloss
- High heat resistance

APPLICATION:

- Air conditioning vent
- Trim

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.19
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.5-0.7
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	58
Elongation at Break	ISO 527	50mm/min	%	50
Tensile Modulus	ISO 527	1mm/min	MPa	2400
Flexural Strength	ISO 178	2mm/min	MPa	76
Flexural Modulus	ISO 178	2mm/min	MPa	2300
Notched Charpy Impact Strength	ISO 179-1eA	4J, 23°C	kJ/m ²	50
Notched Charpy Impact Strength	ISO 179-1eA	4J, -30°C	kJ/m ²	15
Unnotched Charpy Impact Strength	ISO 179-1eU	4J, 23°C	kJ/m ²	NB
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	110
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	128
Other Properties				
Flammability	ISO 3795	355x100x3 mm	mm/min	≤80

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		100-110	°C
Drying Time		4-6	hour
Maximum Moisture Content		0.02	%
General Guidelines			
Barrel Temperature	Rear	220-230	°C
	Middle	240-250	°C
	Front	260-270	°C
Nozzle		250-260	°C
Melt Temperature		250-270	°C
Mold Temperature		≥80	°C

Note :

1. Values are measured at 23°C and in RH of 50% on injection molded specimens.
2. Typical values for uncolored products, not specifications, and may vary slightly with different colors.
3. Flexural strength is tested with fixed deflection.
4. HDT: specimens are unannealed.
5. The general guidelines are only for reference. Exact settings have to follow the product and machine conditions.

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