

HAG7220

HAG7220 is 20%GF ABS resin. HAG7220 is mainly used in axial and centrifuge inertia fan blades of air-condition, automobile parts, camera equipment,etc.

Properties	Standard	Unit	Condition	Typical Value
Physical				
Density	ASTM D792	g/cm3		1.2
Melt Index	ASTM D1238	g/10min	220℃×10kg	8
Mold Shrinkage	ASTM D955	%		0.2~0.4
Mechanical				
Tensile Strength	ASTM D638	MPa		90
Tensile Elongation at Break	ASTM D638	%		4
Flexural Strength	ASTM D790	MPa		120
Flexural Modulus	ASTM D790	MPa		5600
Notched Izod Impact,3.2mm	ASTM D256	J/m	3.2mm,Notched	105
Thermal				
Heat Deflection Temp. 1.82MPa Unannealed	ASTM D648	℃	1.82MPa	100
VICAT	ASTM D1525	℃	B	116
Flammability				
Flammability	UL-94	Class	—	HB
Electrical Properties				
Volume Resistivity	IEC 60093	Ohm-cm	/	> 1.0E+14
Surface Resistivity	IEC 60093	Ohm	/	> 1.0E+14

Note: 1) These are typical property values, not specifications.
 2) In case of colored products, the values could vary slightly by color.
 3) Values are measured at 23℃ and in RH of 50% on injection molded specimens.
 4) UL File No. E65424(CSA File No.LS 66457),E254819.

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Processing Parameters	Typical Value	Unit
Drying Temperature	80~90	℃
Drying Time	3~4	hour
Maximum moisture content	0.05	%
Barrel Temperature		
Rear	200~220	℃
Middle	210~230	℃
Front	210~230	℃
Nozzle	220~240	℃
Melt Temperature	200~230	℃
Mold Temperature	50~80	℃
Back Pressure	1~5	MPa
Screw Speed	30~60	rpm

Note:

1)The above data is only for reference. Exact settings have to follow the product,injection machine and mold.

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