

HAC6010FG

HAC6010FG is 10%GF reinforced flame retardan PC/ABS resin.HAC6010FG has high flame retardant properties and shrinking resistance properties.HAC6010FG is mainly used in printer, copy machine, etc.

Properties	Standard	Unit	Condition	Typical Value
Physical				
Density	ASTM D792	g/cm3		1.27
Melt Inde	ASTM D1238	g/10min	230℃×10kg	16
Mold Shrinkage	ASTM D955	%		0.3~0.5
Mechanical				
Tensile Strength	ASTM D638	MPa		68
Tensile Elongation at Break	ASTM D638	%		7
Flexural Strength	ASTM D790	MPa		110
Flexural Modulus	ASTM D790	MPa		4000
Notched Izod Impact,3.2mm	ASTM D256	J/m	3.2mm,Notched	70
Thermal				
Heat Deflection Temp. 1.82MPa Unannealed	ASTM D648	℃	1.82MPa	120
VICAT	ASTM D1525	℃	B	/
Flammability				
Flammability	UL-94	Class	1.6mm	V-0
Electrical Properties				
Volume Resistivity	IEC 60093	Ohm-cm	/	> 1.0E+15
Surface Resistivity	IEC 60093	Ohm	/	> 1.0E+15

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	90~100	℃
Drying Time	4~6	hour
Maximum moisture content	0.02	%
Barrel Temperature		
Rear	220~240	℃
Middle	240~260	℃
Front	260~270	℃
Nozzle	250~260	℃
Melt Temperature	230~270	℃
Mold Temperature	50~80	℃
Back Pressure	0.3~1	MPa
Screw Speed	30~70	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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