

Technical Data Sheet

HAC8240

PC/ABS

PRODUCT DESCRIPTION:

HAC8240 is a high flow PC/ABS resin. PC/ABS HAC8240 has been used in auto and household appliance.

FEATURES:

- **Balanced toughness and stiffness**
- High flow

APPLICATION:

- Glove box
- Trim

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm ³	1.11
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.5-0.7
Coefficient of Linear Thermal Expansion	ASTM E 831	flow, -30~100°C	×10 ⁻⁵ /°C	7.5
Coefficient of Linear Thermal Expansion	ASTM E 831	cross-flow, -30~100°C	×10 ⁻⁵ /°C	7.9
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	50
Elongation at Break	ISO 527	50mm/min	%	50
Tensile Modulus	ISO 527	1mm/min	MPa	2100
Flexural Strength	ISO 178	2mm/min	MPa	68
Flexural Modulus	ISO 178	2mm/min	MPa	2100
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	52
Notched Charpy Impact	ISO 179	4J, -30°C	kJ/m ²	20
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m ²	NB
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	100
Heat Deflection Temperature	ISO 75	120°C/hr, 0.45MPa	°C	115
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	112
Other Properties				
Flammability	ISO 3795	355×100×3 mm	mm/min	≤80

Processing Parameters		Value	Unit
Pre-treatment			
Drying Temperature		90-100	°C
Drying Time		4-6	hour
Maximum Moisture Content		0.02	%
General Guidelines			
Barrel Temperature	Rear	200-220	°C
	Middle	230-240	°C
	Front	240-250	°C
Nozzle		230-240	°C
Melt Temperature		240-260	°C
Mold Temperature		50-80	°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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