

## Technical Data Sheet

# HAC5020G

## PC/ABS+GF

### PRODUCT DESCRIPTION:

PC/ABSHAC5020G is a good dimensional stability PC/ABS resin with 20% glass fiber reinforced.

### FEATURES:

- High rigidity
- Good surface

### APPLICATION:

- Sunroof ring
- glovebox

Properties	Standard	Condition	Unit	Typical Value
<b>Physical</b>				
Density	ISO 1183	23°C	g/cm <sup>3</sup>	1.27
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.2-0.4
<b>Mechanical</b>				
Tensile Strength at Yield	ISO 527	5mm/min	MPa	100
Flexural Strength	ISO 178	2mm/min	MPa	130
Flexural Modulus	ISO 178	2mm/min	MPa	5300
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m <sup>2</sup>	8
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m <sup>2</sup>	32
<b>Thermal</b>				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	124
<b>Other Properties</b>				
Flammability	ISO 3795	355×100×3 mm	mm/min	≤80

Processing Parameters		Value	Unit
<b>Pre-treatment</b>			
Drying Temperature		110-120	°C
Drying Time		4-6	hour
Maximum Moisture Content		0.02	%
<b>General Guidelines</b>			
Barrel Temperature	Rear	220-240	°C
	Middle	240-260	°C
	Front	270-280	°C
Nozzle		260-270	°C
Melt Temperature		270-280	°C
Mold Temperature		60-100	°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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