Technical Data Sheet

HAC8250P

PC/ABS

PRODUCT DESCRIPTION:

PC/ABSHAC8250P is a high chemical resistance PC/ABS resin. PC/ABSHAC8250P is also a high impact strength and high heat resistance PC/ABS resin.

FEATURES:

- **high chemical resistance**
- high impact strength

APPLICATION:

- rearview mirror
- door handle

Properties	Standard	Condition	Unit	Typical Value
Physical				
Density	ISO 1183	23°C	g/cm^3	1.13
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.5-0.7
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	52
Flexural Strength	ISO 178	2mm/min	MPa	72
Flexural Modulus	ISO 178	2mm/min	MPa	2100
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m^2	50
Notched Charpy Impact	ISO 179	4J, -30°C	kJ/m^2	23
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m^2	NB
Thermal				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	105
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	118
Other Properties				
Flammability	ISO 3795	355×100×3 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	260-265	°C
Nozzle		250-260	°C
Melt Temperature		250-265	°C
Mold Temperature		60-80	°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.