

## Technical Data Sheet

# HAC8244

## PC/ABS

### PRODUCT DESCRIPTION:

PC/ABS HAC8244 is a plating grade PC/ABS resin. HAC8244 has been widely used in automotive interior and exterior parts, such as handle, grille, trim and so on.

### FEATURES:

- High plating peeling strength
- High production yield

### APPLICATION:

- Handle
- Grille

Properties	Standard	Condition	Unit	Typical Value
<b>Physical</b>				
Density	ISO 1183	23°C	g/cm <sup>3</sup>	1.10
Mold Shrinkage	ISO 294	23°C, 48hr	%	0.4-0.6
<b>Mechanical</b>				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	43
Elongation at Break	ISO 527	50mm/min	%	50
Tensile Modulus	ISO 527	1mm/min	MPa	2000
Flexural Strength	ISO 178	2mm/min	MPa	68
Flexural Modulus	ISO 178	2mm/min	MPa	1900
Notched Charpy Impact	ISO 179	4J, 23°C	kJ/m <sup>2</sup>	48
Notched Charpy Impact	ISO 179	4J, -30°C	kJ/m <sup>2</sup>	30
Unnotched Charpy Impact	ISO 179	4J, 23°C	kJ/m <sup>2</sup>	NB
<b>Thermal</b>				
Heat Deflection Temperature	ISO 75	120°C/hr, 1.80MPa	°C	94
Vicat Softening Temperature	ISO 306	50°C/hr, 5kg	°C	110
<b>Other Properties</b>				
Flammability	ISO 3795	355×100×3 mm	mm/min	≤80

Processing Parameters		Value	Unit
<b>Pre-treatment</b>			
Drying Temperature		95-105	°C
Drying Time		4-6	hour
Maximum Moisture Content		0.02	%
<b>General Guidelines</b>			
Barrel Temperature	Rear	230-260	°C
	Middle	240-275	°C
	Front	245-280	°C
Nozzle		245-280	°C
Melt Temperature		250-280	°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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