

SAN ICE-80HF

General Grade

Description

Well processed properties

Application

Blue daily necessities

Properties	Test Method	Test Condition	Unit	Typical Value
Physical		ASTM		
Melt Flow Rate	D1238	220°C/10kg	g/10min	30
Specific Gravity	D792	23°C		1.07
Molding Shrinkage	D955		%	0.2-0.6
Mechanical				
Tensile Strength 3.2mm	D638	10mm/min	kg/cm ²	700
Tensile Elongation 3.2mm	D638	10mm/min	%	8
Flexural Strength 6.4mm	D790	10mm/min	kg/cm ²	1250
Flexural Modulus 6.4mm	D790	10mm/min	kg/cm ²	37000
Izod Impact Strength 6.4mm	D256	23°C	kg.cm/cm	1.2
		-30°C		-
Rockwell Hardness	D785	R-Scale		124
Thermal				
Heat Deflection Temperature, 6.4mm(Unannealed)	D648	18.6kg/cm ²	°C	91
Vicat Softening Temperature	D1525	5kg,50°C/h	°C	107
Flammability	UL94	1.5mm		HB

Note:

- 1) The above values are only the representatives of the natural color specimen, not for guarantee.
- 2) Test block is Natural Color.

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Transparent daily necessities

Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80 ~ 85	
Drying Time	hrs	2 ~ 4	
Cylinder Temperature	Rear	°C	180 ~ 200
	Middle	°C	195 ~ 205
	Front	°C	200 ~ 210
Nozzle Temperature	°C	210 ~ 220	
Melt Temperature	°C	210 ~ 240	
Mold Temperature	°C	40 ~ 80	
Injection pressure	injection pressure	MPa	60 ~ 140
	holding pressure	MPa	70 ~ 90
	Back pressure	MPa	0.5 ~ 1
Screw rotate speed	rpm	50 ~ 100	

Note: These data only a general information to the best of our knowledge. It can not be guaranteed due to variance of materials, conditions and equipments.