KUMHO PETROCHEMICAL

beyond the best

Technical Data Sheet

Heat Resistance Modifier
APH 1550F

Features N-PMI type heat resist co-polymer

Applications Heat booster compounded with ABS, PC, PP, PVC, EP etc.

Physical		Test Method	Value
Density		ASTM D792	1.07 g/cm^3
Melt Flow Index	(230℃, 3.8kg)	ASTM D1238	2.1 g/10min
	(200℃, 5.0kg)	ASTM D1238	0.5 g/10min
Mold Shrinkage		ASTM D955	0.2 ~ 0.6 %
Water absorption		ASTM D570	0.3 %

Mechanical	Test Method	Value
Tensile Strength	ASTM D638	580 kg/cm^2 (8,236) (psi)
Elongation	ASTM D638	4.5 %
Flexural Strength	ASTM D790	780 kg/cm^2 (11,076) (psi)
Flexural Modulus	ASTM D790	34,900 kg/cm^2 (495,580) (psi)
Izod Impact Strength(3.2mm)	ASTM D256	1.5 kgcm/cm (0.28) (ft·lb/in)
Rockwell Hardness(M scale)	ASTM D785	100

Thermal	Test Method	Value
Heat Deflection Temperature(18.6kgf/cm^2)	ASTM D648	122 ℃ (251) (℉)
Vicat Softening Temperature(1kg, 50℃/h)	ASTM D1525	132 ℃ (269) (℉)

Flammability	Test Method	Value
Flame Rating - UL (1.6mm)	UL 94	HB

Notes

These are just typical properties, not specifications. Users should confirm results by their own test.

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Processing guide

Injection Guide	Unit	Value
Nozzle	℃	240~260
Front	℃	230~250
Middle	℃	220~250
Rear	℃	190~210
Hopper Throat	℃	45
Mold	℃	70~80

Drying	Unit	Value
Temperature	℃	80~85
Time	hr	2~4

Notes

These are only mentioned as general guidelines.