

Ravago Manufacturing Americas Hylac® HF96 ABS

Category : Polymer , Thermoplastic , ABS Polymer , Acrylonitrile Butadiene Styrene (ABS), Molded

Material Notes:

Entec's proprietary products include a full range of compounds in the Nylon 6/6, Nylon 6, ABS, PBT, Polycarbonate, PC/ABS, PC/ASA, PC/PBT, and PPO/PPE resin families. Information provided by Ravago.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hylac-HF96-ABS.php

Physical Properties	Metric	English	Comments
Density	1.03 g/cc	0.0372 lb/in ³	ASTM D792
Linear Mold Shrinkage	0.0030 - 0.0070 cm/cm	0.0030 - 0.0070 in/in	0.125 in; ASTM D955
Melt Flow	3.0 g/10 min	3.0 g/10 min	ASTM D1238
	@Load 5.00 kg, Temperature 200 °C	@Load 11.0 lb, Temperature 392 °F	
	8.5 g/10 min	8.5 g/10 min	Cond I; ASTM D1238
	@Load 3.80 kg, Temperature 230 °C	@Load 8.38 lb, Temperature 446 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	102	102	ASTM D785
Tensile Strength, Yield	42.7 MPa	6200 psi	ASTM D638
Elongation at Break	30 %	30 %	ASTM D638
Tensile Modulus	2.48 GPa	360 ksi	ASTM D638
Flexural Yield Strength	63.4 MPa	9200 psi	ASTM D790
Flexural Modulus	2.31 GPa	335 ksi	ASTM D790
Izod Impact, Notched	2.46 J/cm	4.60 ft-lb/in	0.25 in; ASTM D256
	2.94 J/cm	5.50 ft-lb/in	

Thermal Properties	Metric	English	Comments
CTE, linear	115 µm/m-°C	64.0 µin/in-°F	ASTM D696
	@Temperature -40.0 - 176 °C	@Temperature -40.0 - 349 °F	
Deflection Temperature at 0.46 MPa (66 psi)	95.0 °C	203 °F	Unannealed; ASTM D648

Thermal Properties <small>Deflection Temperature at 1.8 MPa (104 psi)</small>	86.7 °C Metric	188 °F English	Unannealed; ASTM D648 Comments
Vicat Softening Point	98.9 °C	210 °F	ASTM D1525
Flammability, UL94	HB	HB	0.0590 in

Electrical Properties	Metric	English	Comments
Volume Resistivity	1.00e+15 ohm-cm	1.00e+15 ohm-cm	ASTM D257

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	179 - 199 °C	355 - 390 °F	
Middle Barrel Temperature	199 - 221 °C	390 - 430 °F	
Front Barrel Temperature	216 - 235 °C	420 - 455 °F	
Nozzle Temperature	210 - 229 °C	410 - 445 °F	
Melt Temperature	241 °C	465 °F	
Mold Temperature	48.9 - 60.0 °C	120 - 140 °F	
Moisture Content	<= 0.10 %	<= 0.10 %	
Injection Pressure	5.86 - 6.89 MPa	850 - 1000 psi	
Back Pressure	0.483 - 0.965 MPa	70.0 - 140 psi	
Shot Size	40 - 80 %	40 - 80 %	
Screw Speed	50 - 90 rpm	50 - 90 rpm	

Descriptive Properties	Value	Comments
Holding Pressure	710 to 850 psi	
Injection Rate	Slow-Moderate	

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