

Ultralloy™ 306

Thermoplastic

Hapco Inc.

Message:

The ULTRALLOY series of liquid molding compounds are tough, fast cycling, low cost, and easy to use. ULTRALLOY is designed to be used with Liquid Molding, open casting, pressure casting, or vacuum casting processes. ULTRALLOY can be used with silicone, epoxy, urethane, polyester, or aluminum molds. Low cost molds and fast cycle times are two key attributes of ULTRALLOY.

ULTRALLOY is available in several series. Each series has different products with different physical properties. Properties such as elongation, tensile strength, and modulus of elasticity can be selected to mold parts with the correct physical characteristics. Choose the ULTRALLOY material with the exact properties you need, or that are required to meet specifications.

ULTRALLOY is available in opaque white, clear/transparent, and in fire retardant (UL 94V-0) versions. Custom coloring can be achieved by pigmenting ULTRALLOY with Hapco's easy to mix color dispersions. Both opaque and translucent color dispersions are available.

ULTRALLOY can be molded in inexpensive molds, reducing total part cost, for short run programs.

ULTRALLOY is made for prototypes and short runs of plastic parts. ULTRALLOY fills the need for low cost, high performance parts, in volumes less than 10,000 parts per year.

ULTRALLOY 300 SERIES

A series of clear, flame retardant (UL94 V-O), Liquid Molding Compounds. These products have a hardness of 85D and are fairly stiff with a flexural strength of over 13,000 psi. These materials are easily pigmented and available in gel times ranging from 8.5 to 60 minutes.

General Information			
UL YellowCard	E151367-223758		
Features	Fast Molding Cycle		
	Flame Retardant		
	Good Toughness		
	Low Viscosity		
Uses	Agricultural Applications		
	Housings		
	Prototyping		
	Thin-walled Parts		
	Toys		
Appearance	Clear/Transparent		
Forms	Liquid		
Processing Method	Casting		
	Vacuum Casting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D4669
Molding Shrinkage - Flow	0.10 to 0.30	%	ASTM D2566
Weight - per cubic inch	14	g	
Gel Time ¹ (25°C)	25.0	min	ASTM D2971
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore D)	85		ASTM D2240

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1360	MPa	ASTM D638
Tensile Strength	61.4	MPa	ASTM D638
Tensile Elongation (Break)	14	%	ASTM D638
Flexural Modulus	2430	MPa	ASTM D790
Flexural Strength	91.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	35	J/m	ASTM D256
Unnotched Izod Impact	500	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed)	60.0	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating	V-0		UL 94
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Part A	Mix Ratio by Weight: 100, Mix Ratio by Volume: 100		
Part B	Mix Ratio by Weight: 100, Mix Ratio by Volume: 110		
Thermoset Mix Viscosity ² (25°C)	225 to 325	cP	ASTM D4878
Demold Time (21°C)	300 to 480	min	Internal Method
NOTE			
1.	100 g		
2.	Range: 225 to 325		

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