

LNP™ COLORCOMP™ HF1130C compound

Polycarbonate
SABIC Innovative Plastics

Message:
COLORCOMP® HF1130C is a compound based on Polycarbonate resin. Added features include: UV Stabilized, Good Clarity, Heat Resistant, Property Retention and Dimensional Stability.

General Information			
Additive	UV stabilizer		
Features	Good dimensional stability		
	Good UV resistance		
	Heat resistance, medium		
	Medium transparency		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.70	%	Internal method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹			ASTM D638
Yield	62.1	MPa	ASTM D638
Fracture	65.5	MPa	ASTM D638
Tensile Elongation ² (Break)	110	%	ASTM D638
Flexural Modulus ³ (50.0 mm Span)	2310	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 50.0 mm Span)	93.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Instrumented Dart Impact (23°C, Energy at Peak Load)	54.2	J	ASTM D3763
Tensile Impact Strength ⁵	378	kJ/m ²	ASTM D1822
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	127	°C	ASTM D648
RTI Elec	130	°C	UL 746
RTI Imp	130	°C	UL 746
RTI	130	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.2 mm)	V-2		UL 94
Optical	Nominal Value	Unit	Test Method
Transmittance (2540 µm)	88.0	%	ASTM D1003

Haze (2540 μm)	1.0	%	ASTM D1003
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 - 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 - 60	%	
Rear Temperature	249 - 271	°C	
Middle Temperature	260 - 282	°C	
Front Temperature	271 - 293	°C	
Nozzle Temperature	266 - 288	°C	
Processing (Melt) Temp	271 - 293	°C	
Mold Temperature	71 - 93	°C	
Back Pressure	0.345 - 0.689	MPa	
Screw Speed	40 - 70	rpm	
Vent Depth	0.025 - 0.076	mm	
NOTE			
1.	Type 1, 50mm/min		
2.	Type 1, 50mm/min		
3.	1.3 mm/min		
4.	1.3 mm/min		
5.	Type S		

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