

LNP™ COLORCOMP™ HF1130RC compound

Polycarbonate

SABIC Innovative Plastics

Message:

COLORCOMP* HF1130RC is a compound based on Polycarbonate resin. Added features include: High Flow, Mold Release, UV Stabilized.

General Information			
Additive	UV stabilizer		
Features	Good UV resistance		
	High liquidity		
	Good demoulding performance		
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 Modulus ¹	2370	MPa	ASTM D638
Tensile Strength ²			ASTM D638
Yield	62.1	MPa	ASTM D638
Fracture	65.5	MPa	ASTM D638
Tensile Elongation ³			ASTM D638
Yield	6.0	%	ASTM D638
Fracture	110	%	ASTM D638
Flexural Modulus ⁴ (50.0 mm Span)	2310	MPa	ASTM D790
Flexural Strength ⁵ (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 ⁶	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
Linear thermal expansion coefficient			ASTM E831
Flow: -40 to 40°C	7.0E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.8E-5	cm/cm/°C	ASTM E831
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. | 5.0 mm/min |
| 2. | Type 1, 50mm/min |
| 3. | Type 1, 50mm/min |
| 4. | 1.3 mm/min |
| 5. | 1.3 mm/min |
| 6. | Type S |

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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