

Ravago Manufacturing Americas Hylac® FR74 ABS

Category : Polymer , Thermoplastic , ABS Polymer , Acrylonitrile Butadiene Styrene (ABS), Unreinforced, Flame Retardant

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-FR74-ABS.php

Physical Properties	Metric	English	Comments
Density	1.17 g/cc	0.0423 lb/in ³	ASTM D792
Linear Mold Shrinkage	0.0030 - 0.0070 cm/cm	0.0030 - 0.0070 in/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	
	7.3 g/10 min	7.3 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	42.1 MPa	6100 psi	ASTM D638
Elongation at Break	23 %	23 %	ASTM D638
Tensile Modulus	2.55 GPa	370 ksi	ASTM D638
Flexural Yield Strength	65.5 MPa	9500 psi	ASTM D790
Flexural Modulus	2.07 GPa	300 ksi	ASTM D790
Izod Impact, Notched	1.60 J/cm	3.00 ft-lb/in	0.25 in; ASTM D256
	1.98 J/cm	3.70 ft-lb/in	73°F, 0.125 in; ASTM D256

Thermal Properties	Metric	English	Comments
CTE, linear	130 µm/m-°C	72.0 µin/in-°F	ASTM D696
	@Temperature -40.0 - 176 °C	@Temperature -40.0 - 349 °F	
Deflection Temperature at 0.46 MPa (66 psi)	90.0 °C	194 °F	Unannealed; ASTM D648

Thermal Properties	Metric	English	Comments
Deflection Temperature at 1.8 MPa (0.04 psi)	80.0 °C	176 °F	Unannealed; ASTM D648
Vicat Softening Point	98.9 °C	210 °F	ASTM D1525
Flammability, UL94	V-0	V-0	0.100 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	160 - 179 °C	320 - 355 °F	
Middle Barrel Temperature	171 - 199 °C	340 - 390 °F	
Front Barrel Temperature	185 - 204 °C	365 - 400 °F	
Nozzle Temperature	177 - 193 °C	350 - 380 °F	
Melt Temperature	229 °C	445 °F	Aim
Mold Temperature	40.6 - 71.1 °C	105 - 160 °F	
Moisture Content	<= 0.10 %	<= 0.10 %	
Injection Pressure	4.90 - 6.89 MPa	710 - 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	570 to 850 psi	
Injection Rate	Slow-Moderate	

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