

## Ravago Manufacturing Americas Hylac® HF224 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-HF224-ABS.php](http://www.lookpolymers.com/polymer_Ravago-Manufacturing-Americas-Hylac-HF224-ABS.php)

Physical Properties	Metric	English	Comments
Density	1.05 g/cc	0.0379 lb/in <sup>3</sup>	ASTM D792
Linear Mold Shrinkage	0.0030 - 0.0070 cm/cm	0.0030 - 0.0070 in/in	ASTM D955
Melt Flow	7.0 g/10 min	7.0 g/10 min	ASTM D1238
	@Load 5.00 kg, Temperature 200 °C	@Load 11.0 lb, Temperature 392 °F	
	22 g/10 min	22 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	113	113	ASTM D785
Tensile Strength, Yield	35.9 MPa	5200 psi	ASTM D638
Elongation at Break	46 %	46 %	ASTM D638
Tensile Modulus	2.59 GPa	375 ksi	ASTM D638
Flexural Yield Strength	56.5 MPa	8200 psi	ASTM D790
Flexural Modulus	2.07 GPa	300 ksi	ASTM D790
Izod Impact, Notched	1.76 J/cm	3.30 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	91.8 µm/m-°C	51.0 µin/in-°F	ASTM D696
	@Temperature -40.0 - 176 °C	@Temperature -40.0 - 349 °F	
Deflection Temperature at 0.46 MPa (66 psi)	97.8 °C	208 °F	Unannealed (0.250 in); ASTM D648

Thermal Properties <small>Deflection Temperature at 1.8 MPa (104 psi)</small>	Metric <small>87.8 °C</small>	English <small>190 °F</small>	Comments <small>Unannealed (0.250 in); ASTM D648</small>
Vicat Softening Point	105 °C	221 °F	ASTM D1525

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	

## Contact Songhan Plastic Technology Co.,Ltd.

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