Solution**Partner**



HI121H Injection Molding Grade

Description

- Well Balanced Mechanical Properties



- Electric/Electronic Products, Miscellaneous Goods



Properties	Method	Unit	HI121H
Physical	Citte	of the China	
Specific Gravity , 23℃	ASTM D792	A MANTECH !	1.05
Mold Shrinkage , 23℃, 3.2mm , 23℃	ASTM D955	%	0.4 ~ 0.7
Melt Flow Rate , 220℃, 10kg	ASTM D1238	g/10min	22
Mechanical			
Tensile Strength at Yield , 23℃, 50mm/min, 3.2mm	ASTM D638	Мра	49
Tensile Elongation at Yield , 23℃, 50mm/min, 3.2mm	ASTM D638	%, (Min)	5
Tensile Elongation at Break , 23℃, 50mm/min, 3.2mm	ASTM D638	%, (Min)	10
Tensile Modulus , 23℃, 50mm/min, 3.2mm	ASTM D638	MPa	2350
Flexural Strength , 23℃, 15mm/min, 3.2mm	ASTM D790	Мра	78
Flexural Modulus , 23℃, 15mm/min, 3.2mm	ASTM D790	MPa	2550
Izod Impact Strength , Notched, 3.2mm, 23℃	ASTM D256	J/m	220
lzod Impact Strength , Notched, 3.2mm, -30℃	ASTM D256	J/m	90
Izod Impact Strength , Notched, 6.4mm, 23℃	ASTM D256	J/m	220
Izod Impact Strength , Notched, 6.4mm, -30℃	ASTM D256	J/m	90
Rockwell Hardness , R-Scale	ASTM D785	The Children	110
Thermal	W FORTCH		ME CHE
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	$^{\circ}$	85
VICAT , 50N, 50℃/h	ASTM D1525	℃ 0	92
RTI Electrical	UL 746B	${\mathbb C}$	95
RTI Mechanical with Impact	UL 746B	C	95
RTI Mechanical without Impact	UL 746B	C	95
Flammability, 1.5mm	UL 94	10 TO	НВ
Flammability, 3.0mm	UL 94	THE WAY	НВ

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors. Values given should not be interpreted as specification and not be used for designing part or tool. All properties, except melt flow rate are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

Updated Date : 17-Nov-17 Issued Date : 6-Mar-18

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Processing Guide (Injection Molding)	All the Color	THE REAL PROPERTY OF THE PARTY
Processing Parameters	Unit	Value
Drying Temperature	C C	70 ~ 80
Drying Time	hrs	2 ~ 4
Minimum Moisture Content	%	0.01
Melt Temperature	°C	210 ~ 240
Cylinder Temperature , Rear	℃	180 ~ 200
Cylinder Temperature, Middle	WIN CO	190 ~ 210
Cylinder Temperature , Front	C C	200 ~ 220
Nozzle Temperature	" selfty " C. C.	200 ~ 230
Mold Temperature	C C	40 ~ 60
Back Pressure, Hydraulic Type	kg/cm²	5 ~ 15
Screw Speed	rpm	30 ~ 60

Note

Back Pressure & Measuring Speed are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.



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