

Heppla® H1100 HF

Material Description:

Heppla® H1100 HF is a unreinforced Acrylonitrile Butadiene Styrene (ABS) product. Characteristics include:High Flow,High Stiffness.

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> Asia Pacific Europe Middle East High Flow Impact Resistant Good Coloring Ability Electrical Insulation
Features	<ul style="list-style-type: none"> North America Latin America Africa High Stiffness Good Dimensional Stability Good Processability
RoHS Compliance	<ul style="list-style-type: none"> RoHS Compliant
Processing Method	<ul style="list-style-type: none"> Injection Molding

Physical Properties	Typical Value	Unit	Test Method
Density/Specific Gravity			
23°C	1.05	g/cm ³	ASTM D792
23°C	1.05	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			
200°C/5.0 kg	4.4	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR)			
220°C/10.0 kg	40	cm ³ /10min	ISO 1133
Molding Shrinkage	0.4 to 0.7	%	ISO 294-4

Hardness	Typical Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785

Mechanical Properties	Typical Value	Unit	Test Method
Tensile Strength			
Yield, 6.0 mm/min	47.5	MPa	ASTM D638
Yield	45.4	MPa	ISO 527-2/50
Break	32.3	MPa	ISO 527-2/50
Tensile Elongation			
Break, 6.0 mm/min	19.5	%	ASTM D638
Break	29	%	ISO 527-2/50
Flexural Modulus			
2.8 mm/min	2642	MPa	ASTM D790
2.0 mm/min	2208	MPa	ISO 178
Flexural Strength			
2.8 mm/min	76	MPa	ASTM D790
2.0 mm/min	73.2	MPa	ISO 178

Impact Properties	Typical Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-30°C	8.9	kJ/m ²	
23°C	16.7	kJ/m ²	
Notched Izod Impact			
23°C, 3.20 mm	167	J/m	ASTM D256
23°C, 6.40 mm	158	J/m	ASTM D256
-30°C	7.9	kJ/m ²	ISO 180/1A
23°C	15.5	kJ/m ²	ISO 180/1A

Flammability	Typical Value	Unit	Test Method
Flame Rating (1.5mm)		HB	UL 94

Thermal Properties	Typical Value	Unit	Test Method
Heat Deflection Temperature			
1.8 MPa, Unannealed	83	°C	ASTM D648,ISO 75-2/A
1.8 MPa, Annealed	95	°C	ASTM D648
1.8 MPa, Annealed	98	°C	ISO 75-2/A
Vicat Softening Temperature			
	105	°C	ASTM D1525 ¹
	104	°C	ISO 306/A50
	96	°C	ISO 306/B50
CLTE - Flow	8.90E-05	cm/cm/°C	ISO 11359-2

Processing Information	Typical Value	Unit
Rear Temperature	180 to 220	°C
Middle Temperature	190 to 230	°C
Front Temperature	190 to 230	°C
Mold Temperature	30 to 70	°C
Drying Temperature	80 to 85	°C
Drying Time	2 to 4	hr

NOTES:

¹Rate A (50°C/h), Loading 1 (10 N)

NFD ADVANCED COMPOSITES

Heppla® H1100 HF

CAUTION/警告!

Before using, read the Molding Guide, Material Safety Data Sheets, and Bulletins available from NFD Advanced Composites Sales offices and Distributors supplied to your company. Caution! During drying, purging and molding, small amounts of hazardous gases and/or particulate matter may be released. These may irritate eyes, nose and throat. Use adequate local exhaust ventilation during thermal processing. To prevent resin decomposition, do not contaminate the resin or exceed the recommended melt temperature or hold-up time. Avoid inhalation or skin and eyes contact. Sweep up and dispose of spilled resin to eliminate slipping hazard. 在使用之前, 请阅读NFD公司销售办事处和经销商提供给贵公司的材料成型指南、材料安全数据表和公告。警告! 在干燥、吹扫和成型过程中, 少量有害气体或颗粒物可能会在被释放, 这些可能会刺激眼睛, 鼻子和喉咙。热处理过程中请注意做好排气通风工作。为防止树脂分解, 请勿污染树脂或超过我们为您推荐熔融温度或时间。请避免吸入或与皮肤、眼睛等接触。清扫和处理溢出的树脂, 以消除滑到的危险。

LEGAL NOTICES/法律声明

The figures indicated here are approximate values. They may be affected by different factors, and the user is not released therefore from the obligation of performing checks and trials of his own. The values indicated here have been compiled on the basis of current tests and findings. Any legally binding guarantee of certain properties, or any suitability for a specific application can not be inferred from the present data. For detailed production regulatory information, contact customer service.

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