Durolon® HFR1900

Polycarbonate

Unigel Plásticos

Message:

Injection molding polycarbonate.
High flow rate product with enhanced mold release performance for parts with complex design.
Product complies with FDA 21 CFR 177.1580.

General Information			
Additive	Mold Release		
Features	Food Contact Acceptable Good Mold Release High Flow		
Agency Ratings	FDA 21 CFR 177.1580		
UL File Number	E102385		
Appearance	Clear/Transparent Colors Available		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	22	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 0.70	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.23	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness			ASTM D785
M-Scale	75		
R-Scale	120		
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2300	MPa	ASTM D638
Tensile Strength			ASTM D638
Yield	63.0	MPa	
Break	68.0	MPa	
Tensile Elongation (Break)	90	%	ASTM D638
Flexural Modulus	2350	MPa	ASTM D790
Flexural Strength	90.0	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	640	J/m	ASTM D256
Thermal	**Nominal Value**	**Unit**	**Test Method**

Deflection Temperature Under Load (1.8 MPa, Unannealed)	128	°C	ASTM D648
CLTE - Flow	6.5E-5	cm/cm/°C	ASTM D696
Electrical	**Nominal Value**	**Unit**	**Test Method**
Volume Resistivity	> 1.0E+16	ohms·cm	ASTM D257
Dielectric Constant			ASTM D150
60 Hz	2.91		
1 MHz	2.85		
Dissipation Factor			ASTM D150
60 Hz	6.6E-4		
1 MHz	9.2E-3		
Arc Resistance	100 to 120	sec	ASTM D495
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (1.50 mm)	HB		UL 94
Glow Wire Ignition Temperature (3.20 mm)	850	°C	IEC 60695-2-13
Optical	**Nominal Value**	**Unit**	**Test Method**
Refractive Index	1.586		ASTM D542
Transmittance	89.0	%	ASTM D1003
Injection	**Nominal Value**	**Unit**	
Drying Temperature	120	°C	
Drying Time	4.0	hr	

Recommended distributors for this material

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