

Technical Information



ALTUGLAS™ HFI 15

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.15 g/cm ³	1.15 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	1.5 g/10 min	1.5 g/10 min	ISO 1133
Molding Shrinkage - Flow	2.0E-3 to 6.0E-3 in/in	0.20 to 0.60 %	ASTM D955
Water Absorption			ISO 62
Equilibrium, 73°F (23°C), 50% RH	0.36 %	0.36 %	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Tensile Stress (Break, 73°F (23°C))	7250 psi	50.0 MPa	ISO 527-2/50
Tensile Strain (Break, 73°F (23°C))	65 %	65 %	ISO 527-2/50
Flexural Modulus (73°F (23°C))	290000 psi	2000 MPa	ISO 178
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	3.1 ft-lb/in ²	6.5 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
73°F (23°C)	43 ft-lb/in ²	90 kJ/m ²	
Notched Izod Impact Strength (73°F (23°C))	2.9 ft-lb/in ²	6.0 kJ/m ²	ISO 180/1A
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (M-Scale)	50	50	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ISO 75-2/A
264 psi (1.8 MPa), Annealed	189 °F	87.0 °C	
Vicat Softening Temperature	> 201 °F	> 94.0 °C	ISO 306/B50
CLTE - Flow (-22 to 73°F (-30 to 23°C))	5.6E-5 in/in/°F	1.0E-4 cm/cm/°C	ASTM D696
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating	HB	HB	UL 94
Optical	Nominal Value (English)	Nominal Value (SI)	Test Method
Refractive Index ¹	1.490	1.490	ISO 489
Light Transmittance (78.74 mil (2000 µm))	91.0 %	91.0 %	ASTM D1003
Haze	1.50 %	1.50 %	ASTM D1003
Injection	Nominal Value (English)	Nominal Value (SI)	
Drying Temperature	176 °F	80 °C	
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr	
Rear Temperature	428 to 464 °F	220 to 240 °C	
Middle Temperature	446 to 482 °F	230 to 250 °C	
Front Temperature	464 to 500 °F	240 to 260 °C	
Nozzle Temperature	464 to 500 °F	240 to 260 °C	
Processing (Melt) Temp	464 to 500 °F	240 to 260 °C	
Mold Temperature	167 to 185 °F	75 to 85 °C	

Notes

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

¹ Method B

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