

Technical Information



ALTUGLAS™ HFI-10 Smooth Matt

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.18 g/cm ³	1.18 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	3.0 g/10 min	3.0 g/10 min	ISO 1133
Molding Shrinkage - Flow	2.0E-3 to 8.0E-3 in/in	0.20 to 0.80 %	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			ISO 527-2/50
Yield, 73°F (23°C)	5080 psi	35.0 MPa	
Break, 73°F (23°C)	5220 psi	36.0 MPa	
Tensile Strain			ISO 527-2/50
Yield, 73°F (23°C)	5.0 %	5.0 %	
Break, 73°F (23°C)	35 %	35 %	
Flexural Modulus (73°F (23°C))	203000 psi	1400 MPa	ISO 178
Flexural Stress (73°F (23°C))	6090 psi	42.0 MPa	ISO 178
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Charpy Notched Impact Strength (73°F (23°C))	1.9 ft·lb/in ²	4.0 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
73°F (23°C)	24 ft·lb/in ²	51 kJ/m ²	
Notched Izod Impact Strength (73°F (23°C))	1.9 ft·lb/in ²	4.0 kJ/m ²	ISO 180/1A
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (M-Scale)	29	29	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	185 °F	85.0 °C	
Vicat Softening Temperature	> 192 °F	> 89.0 °C	ISO 306/B50
Flammability	Nominal Value (English)	Nominal Value (SI)	Test Method
Flame Rating	HB	HB	UL 94
Optical	Nominal Value (English)	Nominal Value (SI)	Test Method
Light Transmittance (11.81 mil (300 µm))	93.0 %	93.0 %	ASTM D1003
Haze (11.81 mil (300 µm))	89.0 %	89.0 %	ASTM D1003
Injection	Nominal Value (English)	Nominal Value (SI)	
Drying Temperature	167 °F	75 °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	158 to 176 °F	70 to 80 °C	

Notes

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

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