

Technical Information



ALTUGLAS™ HT121 LPL

Physical	Nominal Value (English)	Nominal Value (SI)	Test Method
Density	1.19 g/cm ³	1.19 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (230°C/3.8 kg)	2.0 g/10 min	2.0 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	0.40 %	0.40 %	
Mechanical	Nominal Value (English)	Nominal Value (SI)	Test Method
Flexural Modulus	476000 psi	3280 MPa	ASTM D790
Flexural Strength (Break)	15200 psi	105 MPa	ASTM D790
Impact	Nominal Value (English)	Nominal Value (SI)	Test Method
Notched Izod Impact (73°F (23°C))	0.30 ft-lb/in	16 J/m	ASTM D256
Hardness	Nominal Value (English)	Nominal Value (SI)	Test Method
Rockwell Hardness (M-Scale)	102	102	ASTM D785
Thermal	Nominal Value (English)	Nominal Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi (0.45 MPa), Annealed	235 °F	113 °C	
264 psi (1.8 MPa), Annealed	226 °F	108 °C	
Vicat Softening Temperature	246 °F	119 °C	ASTM D1525 ¹
Thermal Conductivity	1.3 Btu-in/hr/ft ² /°F	0.19 W/m/K	ASTM C177
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	1.490	1.490	ASTM D542
Light Transmittance (125.0 mil (3175 µm))	92.0 %	92.0 %	ASTM D1003
Haze (125.0 mil (3175 µm))	< 1.00 %	< 1.00 %	ASTM D1003
Injection	Nominal Value (English)	Nominal Value (SI)	
Drying Temperature	194 to 212 °F	90 to 100 °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	176 to 194 °F	80 to 90 °C	

Notes

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

¹ Rate A (50°C/h), Loading 2 (50 N)

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