

**Hylac® HF224**

ABS

Ravago Manufacturing Americas

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	<b>70</b>	g/10min	ISO 1133
Temperature	<b>220</b>	°C	-
Load	<b>10</b>	kg	-
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>7</b>	g/10min	ASTM D 1238
Temperature	<b>200</b>	°C	-
Load	<b>5</b>	kg	-
Mold Shrinkage, MD	<b>0.005</b>	mm/mm	ASTM D 955

<b>Mechanical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Tensile Modulus	<b>2590</b>	MPa	ASTM D 638
Tensile Strength at Yield	<b>35.9</b>	MPa	ASTM D 638
Elongation at Break	<b>46</b>	%	ASTM D 638
Flexural Modulus	<b>2070</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 113</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>200</b>	J/m	ASTM D 256
Izod Impact notched, 1/4 in	<b>180</b>	J/m	ASTM D 256

<b>Thermal properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Coefficient of Thermal Expansion, MD	<b>92</b>	E-6/K	ASTM D 696
DTUL @ 66 psi	<b>97.8</b>	°C	ASTM D 648
DTUL @ 264 psi	<b>87.8</b>	°C	ASTM D 648
Vicat Temperature	<b>105</b>	°C	ASTM D 1525

<b>Electrical properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Volume Resistivity	<b>1E15</b>	Ohm*cm	ASTM D 257

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Density	<b>1050</b>	kg/m <sup>3</sup>	ASTM D 792

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Natural Color

**Regional Availability**

North America