

# HP100H

## Description

HP100H is a grade apply for injection molding products with high impact, low temperature resistance and satisfactory spray paint effect.

## Key Features

Opacity, Hot Stamping, Paintability,  
Multi-axial Impact Strength, High  
Stiffness, High Impact Strength

## Application

Helmets, watches, refrigerators

## Plant

China(Huizhou)

Properties	Condition	Method	Unit	HP100H
<b>Physical</b>				
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	6
<b>Mechanical</b>				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	MPa	42
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	63
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	MPa	2100
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	J/m	45
Rockwell Hardness	R-Scale	ASTM D785		102
<b>Thermal</b>				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	84

## Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

Values given should not be interpreted as specification and not be used for designing part or tool.

All properties, except melt flow index are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

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## Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	70~80
Drying Time	hrs	2~4
Injection Temperature	°C	200~250
Mold Temperature	°C	40~80
Screw Speed	rpm	30~60

## Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.