



HINDUSTAN BACKLITE COMPANY

MANUFACTURERS OF
P.F. MOULDING POWDER AND P.F. RESIN

WHOME EVER IT MAY CONCERN
THIS ARE THE SEPCIFICATION FOR GRADE HB – 1140 IS AS UNDER.

GRADE HB – 1140 (LIGHT BROWN)

FILLER	WOOD FLOUR
COLOR	LIGHT BROWN
<u>RATE OF CURE</u>	
1) MINIMUM CURE IN SECOND AT 160 °C per mm THICKNESS	35 - 55
<u>MOULDING CONDITIONS</u>	
1) MOULDING TEMPERATURE °C	150° TO 170° C
2) MOULDING PRESSURE (Kg/cm ²)	157 - 315
<u>POWDER PROPERTIES</u>	
1) APPARENT DENSITY (Kg/ml)	0.65 - 0.70
2) BULK FACTOR	2.00 - 2.40
3) MOULD SHRINKAGE (inch per inch)	0.003 - 0.008
4) PELLETILNG PROPERTIES	GOOD
<u>PHYSICAL PROPERTIES OF MOULDING</u>	
1) Sp. GRAVITY	1.34 - 1.39
2) IMPACT STRENGTH (kg. m.)	0.015 - 0.020
3) TENSILE STRENGTH (kg. cm ²)	460 - 530
4) CROSS BREAKING STRENGTH (kg. cm ²)	580 - 670
<u>ELECTRICAL PROPERTIES</u>	
1) ELECTRICAL STRENGTH V/r mm AT 90 °C	6500 - 7000
2) VOLUME RESISTIVITY (log 10 ohm em)	12 - 12.5
3) SURFACE RESISTIVITY (log 10 ohms)	12 - 12.5