

TECHNICAL DATA SHEET

# INFINO NH-1017

Lotte Chemical Corporation  
(PC+ABS)

**Processing**

Injection molding

Pellets, Natural color

**Applications**

Electrical and electrical

**Delivery Form**

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	55	g/10min	ISO 1133
Temperature	220	°C	
Load	10	kg	
Molding shrinkage, parallel	0.25	%	ISO 294-4, 2577
Molding shrinkage, normal	0.3	%	ISO 294-4, 2577
Melt flow index, MFI	55	g/10min	ASTM D 1238
Temperature	220	°C	
Load	10	kg	
Mold shrinkage, MD	0.0025	mm/mm	ASTM D 955
Mold shrinkage, TD	0.003	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Tensile modulus	2400	MPa	ISO 527
Yield stress	59	MPa	ISO 527
Stress at break	44	MPa	ISO 527
Strain at break	10	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2350	MPa	ISO 178
Flexural strength	83	MPa	ISO 178
Charpy notched impact strength, +23°C	14	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	13	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 113		ISO 2039-2
Tensile modulus	2400	MPa	ASTM D 638
Tensile strength at yield	53	MPa	ASTM D 638

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Mechanical Properties	Value	Unit	Standard
Tensile strength at break	43	MPa	ASTM D 638
Elongation at break	8.8	%	ASTM D 638
Flexural modulus	2100	MPa	ASTM D 790
Flexural strength	74	MPa	ASTM D 790
Rockwell hardness	R 113		ASTM D 785
Izod impact notched, 1/8 in	440	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	75	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	85	°C	ISO 75-1/-2
Vicat softening temperature, B	91	°C	ISO 306
Burning behav. at thickness h	V-0	class	IEC 60695-11-10
Thickness tested	2	mm	
Burning behav. 5V at thickness h	5VB	class	IEC 60695-11-20
Thickness tested	2	mm	
UL 94 flame rating	V-0		UL 94
Thickness tested	2	mm	
DTUL @ 66 psi	87	°C	ASTM D 648
DTUL @ 264 psi	80	°C	ASTM D 648
Other Properties	Value	Unit	Standard
Density	1170	kg/m <sup>3</sup>	ISO 1183
Density	1170	kg/m <sup>3</sup>	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	80	°C	
Pre-drying - time	4 - 6	h	
Processing humidity	≤0.05	%	
Melt temperature	260	°C	
Mold temperature	50 - 70	°C	
Zone 1	220 - 230	°C	
Zone 2	240 - 250	°C	
Zone 3	260 - 270	°C	
Nozzle temperature	270	°C	
Screw speed	50 - 150	rpm	

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Processing Recommendation Injection Molding	Value	Unit	Standard
Injection pressure	98	MPa	
Back pressure	0.5 - 2	MPa	