

TECHNICAL DATA SHEET

INFINO NH-1035

Lotte Chemical Corporation
PC

Processing

Injection molding

Delivery Form

Pellets, Natural color

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	35	g/10min	ISO 1133
Temperature	250	°C	
Load	10	kg	
Molding shrinkage, parallel	0.55	%	ISO 294-4, 2577
Molding shrinkage, normal	0.55	%	ISO 294-4, 2577
Melt flow index, MFI	35	g/10min	ASTM D 1238
Temperature	250	°C	
Load	10	kg	
Mold shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold shrinkage, TD	0.0055	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Tensile modulus	2200	MPa	ISO 527
Yield stress	59	MPa	ISO 527
Stress at break	57	MPa	ISO 527
Strain at break	88	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy notched impact strength, +23°C	55	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	54	kJ/m ²	ISO 180/1A
Rockwell hardness	R 120		ISO 2039-2
Tensile modulus	2200	MPa	ASTM D 638
Tensile strength at yield	59	MPa	ASTM D 638
Tensile strength at break	56	MPa	ASTM D 638

INFINO NH-1035

Lotte Chemical Corporation

Mechanical Properties	Value	Unit	Standard
Elongation at break	40	%	ASTM D 638
Flexural modulus	2500	MPa	ASTM D 790
Flexural strength	88	MPa	ASTM D 790
Rockwell hardness	R 120		ASTM D 785
Izod impact notched, 1/8 in	690	J/m	ASTM D 256
Izod impact notched, 1/4 in	150	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	107	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	120	°C	ISO 75-1/-2
Vicat softening temperature, B	127	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-0	class	IEC 60695-11-10
Thickness tested	1.5	mm	
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	1.5	mm	
DTUL @ 264 psi	113	°C	ASTM D 648
Other Properties	Value	Unit	Standard
Density	1200	kg/m ³	ISO 1183
Density	1200	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	120	°C	
Pre-drying - time	2 - 6	h	
Processing humidity	≤0.05	%	
Melt temperature	290 - 310	°C	
Mold temperature	40 - 100	°C	
Zone 1	240 - 250	°C	
Zone 2	260 - 270	°C	
Zone 3	280 - 310	°C	
Screw speed	50 - 150	rpm	

INFINO NH-1035

Lotte Chemical Corporation

Processing Recommendation Injection Molding	Value	Unit	Standard
Injection pressure	49 - 250	MPa	
Back pressure	0.5 - 2	MPa	