

# Infino VB-3100G

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene + PBT

## General Information

### General

Filler / Reinforcement	• Glass Fiber
Uses	• Appliances • Electrical/Electronic Applications

## Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.45		ASTM D792
Density (Natural)	1.45	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	30	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	30	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	8.0E-3 to 0.011	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	5.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.50 to 0.80	%	
Flow : 0.0787 in	0.80 to 1.1	%	
Water Absorption (Saturation, 73°F)	0.080	%	ASTM D570
Water Absorption (Saturation, 73°F)	0.080	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	10700	psi	ASTM D638
Tensile Stress (Yield)	10200	psi	ISO 527-2/5
Tensile Elongation <sup>2</sup> (Break)	4.0	%	ASTM D638
Tensile Strain (Break)	4.0	%	ISO 527-2/5
Flexural Modulus <sup>3</sup>	569000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	508000	psi	ISO 178
Flexural Strength <sup>3</sup>	14200	psi	ASTM D790
Flexural Stress <sup>4</sup>	13100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	1.9	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	0.92	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	1.9	ft·lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Rockwell Hardness (R-Scale)	113		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	275	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	257	°F	
Vicat Softening Temperature			
--	302	°F	ISO 306/B120
--	302	°F	ISO 306/B50
--	297	°F	

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-0	
0.12 in		V-0	

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	212	°F
Hot Air Dryer	212	°F
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	4.0 to 6.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	410 to 428	°F
Middle Temperature	437 to 446	°F
Front Temperature	464 to 482	°F
Nozzle Temperature	482	°F
Mold Temperature	140 to 248	°F
Injection Pressure	7110 to 35600	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

#### Injection Notes

Hot Runner Temperature: 250°C

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 0.20 in/min

<sup>3</sup> 0.11 in/min

<sup>4</sup> 0.079 in/min

<sup>5</sup> 4mm