Infino GP-3200G

Lotte Chemical Corporation - Acrylonitrile Butadiene Styrene + PBT

General Information	
General	
Filler / Reinforcement	• Glass Fiber
Uses	• Appliances

Properties [1]			
Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity (Natural)	1.32		ASTM D792
Density (Natural)	1.32	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	33	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	33	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 9.0E-3	in/in	ASTM D955
Water Absorption (Saturation, 73°F)	0.080	%	ASTM D570
Ash Content			
--	19	%	ASTM D5630
--	19	%	ISO 3451
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [2]	711000	psi	ASTM D638
Tensile Modulus	725000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	11400	psi	ASTM D638
Tensile Stress (Yield)	13200	psi	ISO 527-2/50
Tensile Strength [2] (Break)	11400	psi	ASTM D638
Tensile Stress (Break)	13100	psi	ISO 527-2/50
Tensile Elongation [2] (Break)	3.2	%	ASTM D638
Tensile Strain (Break)	3.6	%	ISO 527-2/50
Flexural Modulus [3]	711000	psi	ASTM D790
Flexural Modulus [4]	725000	psi	ISO 178
Flexural Strength [3]	17100	psi	ASTM D790
Flexural Stress [4]	18900	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	3.9	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	1.2	ft·lb/in	
73°F, 0.250 in	1.2	ft·lb/in	
Notched Izod Impact Strength [5] (73°F)	3.6	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	112		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	401	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	388	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	293	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	261	°F	
Vicat Softening Temperature			
--	• 268 • 279	°F	ISO 306/B120
--	• 264 • 271	°F	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	HB		
0.12 in	HB		

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

[1] Typical properties: these are not to be construed as specifications.

[2] 0.20 in/min

[3] 0.11 in/min

[4] 0.079 in/min

[5] 4mm