Infino HM-3301GL

Lotte Chemical Corporation - Polycarbonate

General Information

General	
Filler / Reinforcement	• Glass Fiber
RoHS Compliance	• RoHS Compliant

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.41		ASTM D792
Density (Natural)	1.39	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	7.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	5.4	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	1.0E-3 to 3.0E-3	in/in	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	1.04E+6	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	19600	psi	ASTM D638
Tensile Stress (Yield)	16700	psi	ISO 527-2/50
Tensile Stress (Break)	16700	psi	ISO 527-2/50
Tensile Strain (Break)	2.7	%	ISO 527-2/50
Flexural Modulus [3]	1.11E+6	psi	ASTM D790
Flexural Modulus [4]	1.15E+6	psi	ISO 178
Flexural Strength [3]	28400	psi	ASTM D790
Flexural Stress [4]	22200	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	5.2	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	2.6	ft·lb/in	ASTM D256
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	93		ASTM D785
Rockwell Hardness (R-Scale)	119		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	295	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	289	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	288	°F	
Vicat Softening Temperature			
-- • 304 • 306		°F	ISO 306/B120
--	302	°F	ISO 306/B50
Electrical	**Nominal Value**	**Unit**	**Test Method**
Dielectric Constant (10 MHz)	3.30		ASTM D150
Dielectric Loss - Tangent [6]	0.00900		ASTM D150

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	• V-2 • V-1		
0.12 in	V-0		
0.24 in	V-0		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	248	°F
Hot Air Dryer	248	°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	464 to 482	°F
Middle Temperature	500 to 518	°F
Front Temperature	536 to 554	°F
Nozzle Temperature	554	°F
Mold Temperature	140 to 212	°F
Injection Pressure	9960 to 32700	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 280°C

Notes

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

[2] 2.0 in/min

[3] 0.11 in/min

[4] 0.079 in/min

[5] 4mm

[6] 10E6Hz