

Infino NH-3200

Lotte Chemical Corporation - Polycarbonate

General Information

General

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

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.34		ASTM D792
Density (Natural)	1.34	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/5.0 kg	19	g/10 min	
300°C/1.2 kg	12	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/5.0 kg	19	g/10 min	
300°C/1.2 kg	12	g/10 min	
Molding Shrinkage - Flow (0.126 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.10 to 0.40	%	
Flow : 0.0787 in	0.10 to 0.40	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	711000	psi	ASTM D638
Tensile Modulus	725000	psi	ISO 527-1/5
Tensile Strength ² (Yield)	17100	psi	ASTM D638
Tensile Stress (Yield)	17400	psi	ISO 527-2/5
Tensile Strength ² (Break)	17100	psi	ASTM D638
Tensile Stress (Break)	17400	psi	ISO 527-2/5
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ³	853000	psi	ASTM D790
Flexural Modulus ⁴	870000	psi	ISO 178
Flexural Strength ³	21300	psi	ASTM D790
Flexural Stress ⁴	21800	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	4.8	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	1.8	ft·lb/in	
73°F, 0.250 in	1.8	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	4.8	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Rockwell Hardness (R-Scale)	120		ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	221	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	216	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	212	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	207	°F	ISO 75-2/A
Flammability	Nominal Value	Unit	Test Method
Flame Rating 0.030 in 0.12 in	V-0 V-0		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature Desiccant Dryer Hot Air Dryer	176	°F
Drying Time Desiccant Dryer Hot Air Dryer	3.0 to 4.0 4.0 to 6.0	hr
Suggested Max Moisture	0.040	%
Rear Temperature	500 to 518	°F
Middle Temperature	518 to 554	°F
Front Temperature	500 to 536	°F
Nozzle Temperature	518	°F
Mold Temperature	140 to 158	°F
Injection Pressure	14200	psi
Back Pressure	142 to 284	psi
Screw Speed	30 to 100	rpm

Injection Notes

Hot Runner Temperature: 270°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