Infino HN-1074

Lotte Chemical Corporation - Polycarbonate

General Information

General

Uses	• Appliances

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.20		ASTM D792
Density (Natural)	1.20	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	23	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	23	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	5.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.50 to 0.70	%	
Flow : 0.0787 in	0.50 to 0.70	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [2]	2.56E+6	psi	ASTM D638
Tensile Modulus	261000	psi	ISO 527-1/50
Tensile Strength [2] (Yield)	8960	psi	ASTM D638
Tensile Stress (Yield)	8700	psi	ISO 527-2/50
Tensile Strength [2] (Break)	8530	psi	ASTM D638
Tensile Stress (Break)	8700	psi	ISO 527-2/50
Tensile Elongation [2] (Break)	95	%	ASTM D638
Tensile Strain (Break)	95	%	ISO 527-2/50
Flexural Modulus [3]	313000	psi	ASTM D790
Flexural Modulus [4]	305000	psi	ISO 178
Flexural Strength [3]	11400	psi	ASTM D790
Flexural Stress [4]	11900	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	4.8	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	2.2	ft·lb/in	
73°F, 0.250 in	1.8	ft·lb/in	
Notched Izod Impact Strength [5] (73°F)	4.8	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	119		ASTM D785
Rockwell Hardness (R-Scale)	119		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	262	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	248	°F	

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	284	°F	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.030 in	V-2		
0.06 in	V-0		
0.12 in	V-0		
0.08 in	5VB		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	212 to 248	°F
Hot Air Dryer	212 to 248	°F
Drying Time		
Desiccant Dryer	3.0 to 4.0	hr
Hot Air Dryer	3.0 to 4.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	428 to 500	°F
Middle Temperature	464 to 536	°F
Front Temperature	500 to 572	°F
Nozzle Temperature	500 to 572	°F
Mold Temperature	158 to 212	°F
Injection Pressure	9960 to 18500	psi
Back Pressure	142 to 284	psi
Screw Speed	60 to 90	rpm

Injection Notes

Hot Runner Temperature: 260 to 300°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