

# Infino HN-3107

Lotte Chemical Corporation - Polycarbonate

## General Information

### General

Filler / Reinforcement • Glass Fiber

### Properties<sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.28		ASTM D792
Density (Natural)	1.28	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	9.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	9.0	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.30 to 0.60	%	
Flow : 0.0787 in	0.30 to 0.60	%	
Ash Content			
--	11	%	ASTM D5630
--	11	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	498000	psi	ASTM D638
Tensile Modulus	508000	psi	ISO 527-1/5
Tensile Strength <sup>2</sup> (Break)	7820	psi	ASTM D638
Tensile Stress (Break)	8700	psi	ISO 527-2/5
Tensile Elongation <sup>2</sup> (Break)	6.0	%	ASTM D638
Tensile Strain (Break)	6.0	%	ISO 527-2/5
Flexural Modulus <sup>3</sup>	498000	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)	4.8	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	1.8	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	4.8	ft·lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Rockwell Hardness (R-Scale)	115		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	284	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	279	°F	

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## Lotte Chemical Corporation - Polycarbonate

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-0	
0.12 in	•	V-0	
	•	5VA	

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	212	°F
Hot Air Dryer	212	°F
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	536 to 554	°F
Middle Temperature	554 to 572	°F
Front Temperature	572 to 590	°F
Nozzle Temperature	572 to 590	°F
Mold Temperature	176 to 212	°F
Injection Pressure	14200	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

#### Injection Notes

Hot Runner Temperature: 300 to 310°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