

Infino HN-3104

Lotte Chemical Corporation - Polycarbonate

General Information

General			
Filler / Reinforcement	• Glass Fiber		
Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.28		ASTM D792
Density (Natural)	1.28	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	13	g/10 min	
300°C/1.2 kg	9.0	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	13	g/10 min	
300°C/1.2 kg	9.0	g/10 min	
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 ²	498000	psi	ASTM D638
Tensile Modulus	508000	psi	ISO 527-1/5
Tensile Strength ² (Yield)	7820	psi	ASTM D638
Tensile Stress (Yield)	8700	psi	ISO 527-2/5
Tensile Strength ² (Break)	7820	psi	ASTM D638
Tensile Stress (Break)	8700	psi	ISO 527-2/5
Tensile Elongation ² (Break)	6.0	%	ASTM D638
Tensile Strain (Break)	6.0	%	ISO 527-2/5
Flexural Modulus ³	498000	psi	ASTM D790
Flexural Modulus ⁴	508000	psi	ISO 178
Flexural Strength ³	14200	psi	ASTM D790
Flexural Stress ⁴	13100	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	1.5	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)	115		ASTM D785

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Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	293	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	289	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	284	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	279	°F	ISO 75-2/A
Vicat Softening Temperature	288	°F	ISO 306/B50
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI)	PLC 3		IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.030 in		HB	
0.05 in		V-1	
0.06 in		V-0	
0.10 in	•	V-0	
	•	5VB	
0.12 in	•	V-0	
	•	5VA	
Glow Wire Flammability Index			IEC 60695-2-12
0.06 in	1760	°F	
0.12 in	1760	°F	

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	590	°F
Mold Temperature	176 to 194	°F
Injection Pressure	1420	psi
Back Pressure	9960 to 11400	psi
Screw Speed	50 to 100	rpm

Injection Notes

Hot Runner Temperature: 300 to 310°C