Infino CF-3200HF

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)	1.33		ASTM D792
Density (Natural)	1.33	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	23	g/10 min	
300°C/1.2 kg	11	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	23	g/10 min	
300°C/1.2 kg	11	g/10 min	
Molding Shrinkage - Flow (0.126 in)	2.0E-3 to 5.0E-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	0.20 to 0.50	%	
Water Absorption (Saturation, 73°F)	0.15	%	ASTM D570
Water Absorption (Saturation, 73°F)	0.15	%	ISO 62
Ash Content			
--	20	%	ASTM D5630
--	20	%	ISO 3451

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus [2]	768000	psi	ASTM D638
Tensile Modulus	827000	psi	ISO 527-1/5
Tensile Strength [2] (Yield)	14200	psi	ASTM D638
Tensile Stress (Yield)	14500	psi	ISO 527-2/5
Tensile Strength [2] (Break)	14200	psi	ASTM D638
Tensile Stress (Break)	14500	psi	ISO 527-2/5
Tensile Elongation [2] (Break)	4.3	%	ASTM D638
Tensile Strain (Break)	4.3	%	ISO 527-2/5
Flexural Modulus [3]	797000	psi	ASTM D790
Flexural Modulus [4]	870000	psi	ISO 178
Flexural Strength [3]	19900	psi	ASTM D790
Flexural Stress [4]	24700	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength [5] (73°F)	12	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.6	ft·lb/in	
73°F, 0.250 in	3.7	ft·lb/in	

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Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength [5] (73°F)	9.0	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	116		ASTM D785
Rockwell Hardness (R-Scale)	116		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	293	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	291	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	286	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	282	°F	
Vicat Softening Temperature	298	°F	ISO 306/B50
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating			UL 94
0.031 in	V-2		
0.13 in	V-1		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	212	°F
Hot Air Dryer	212	°F
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	4.0 to 6.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	518	°F
Middle Temperature	536 to 554	°F
Front Temperature	572 to 608	°F
Nozzle Temperature	572 to 608	°F
Mold Temperature	176 to 248	°F
Injection Pressure	14200	psi
Back Pressure	142 to 427	psi
Screw Speed	40 to 80	rpm

Injection Notes

Hot Runner Temperature: 300 to 320 °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