

# Infino HN-3102G

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)	1.26		ASTM D792
Density (Natural)	1.27	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	33	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	31	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 4.0E-3	in/in	ASTM D955
Ash Content	10	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	469000	psi	ASTM D638
Tensile Modulus	479000	psi	ISO 527-1/5
Tensile Strength <sup>2</sup> (Yield)	12200	psi	ASTM D638
Tensile Stress (Yield)	10900	psi	ISO 527-2/5
Tensile Strength <sup>2</sup> (Break)	9250	psi	ASTM D638
Tensile Stress (Break)	10000	psi	ISO 527-2/5
Tensile Elongation <sup>2</sup> (Break)	5.2	%	ASTM D638
Tensile Strain (Break)	5.6	%	ISO 527-2/5
Flexural Modulus <sup>3</sup>	583000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	537000	psi	ISO 178
Flexural Strength <sup>3</sup>	21300	psi	ASTM D790
Flexural Stress <sup>4</sup>	17400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	2.8	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	1.0	ft·lb/in	
73°F, 0.250 in	0.92	ft·lb/in	
Notched Izod Impact Strength <sup>5</sup> (73°F)	2.7	ft·lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	90		ASTM D785
Rockwell Hardness (R-Scale)	90		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	288	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	284	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	279	°F	

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	270	°F	ISO 75-2/A
Vicat Softening Temperature			
--	295	°F	ISO 306/B120
--	289	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 in)	• •	V-0 V-0	UL 94

### 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	< 0.050	%
Rear Temperature	500	°F
Middle Temperature	500	°F
Front Temperature	518	°F
Nozzle Temperature	518	°F
Mold Temperature	122 to 140	°F
Injection Pressure	13500	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

#### Injection Notes

Hot Runner Temperature: 270°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