

Infino CF-3104HF

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)	1.25		ASTM D792
Density (Natural)	1.25	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	23	g/10 min	
300°C/1.2 kg	13	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	23	g/10 min	
300°C/1.2 kg	13	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)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.70	%	
Flow : 0.0787 in	0.30 to 0.60	%	
Water Absorption (Saturation, 73°F)	0.30	%	ASTM D570
Water Absorption (Saturation, 73°F)	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	462000	psi	ASTM D638
Tensile Strength ² (Yield)	8530	psi	ASTM D638
Tensile Stress (Yield)	8700	psi	ISO 527-2/50
Tensile Strength ² (Break)	5970	psi	ASTM D638
Tensile Elongation ² (Break)	15	%	ASTM D638
Flexural Modulus ³	427000	psi	ASTM D790
Flexural Modulus ³	435000	psi	ISO 178
Flexural Strength ³	13500	psi	ASTM D790
Flexural Stress ³	13800	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁴ (73°F)	9.5	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	5.2	ft·lb/in	
73°F, 0.250 in	3.7	ft·lb/in	
Notched Izod Impact Strength ⁴ (73°F)	9.5	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	279	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	279	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	286	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	286	°F	ISO 75-2/A
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 2.0 in/min

³ 0.079 in/min

⁴ 4mm