

# Infino NH-3204G

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)	1.34		ASTM D792
Density (Natural)	1.34	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	36	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	36	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.20 to 0.50	%	
Flow : 0.0787 in	0.20 to 0.50	%	
Ash Content			
--	20	%	ASTM D5630
--	20	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	15600	psi	ASTM D638
Tensile Stress (Yield)	14500	psi	ISO 527-2/5
Flexural Modulus <sup>3</sup>	334000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	870000	psi	ISO 178
Flexural Strength <sup>3</sup>	21200	psi	ASTM D790
Flexural Stress <sup>4</sup>	21200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	3.8	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	1.7	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	3.3	ft·lb/in <sup>2</sup>	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	237	°F	
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in		V-1	
0.08 in	•	V-0	
	•	5VB	
0.10 in	•	V-0	
	•	5VB	
0.12 in	•	V-0	
	•	5VB	

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## Lotte Chemical Corporation - Polycarbonate

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	248	°F
Hot Air Dryer	248	°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	464 to 482	°F
Middle Temperature	500 to 518	°F
Front Temperature	536 to 554	°F
Nozzle Temperature	554	°F
Mold Temperature	158 to 212	°F
Injection Pressure	9960 to 32700	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

### Injection Notes

Hot Runner Temperature: 280°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