

Infino NH-3250MF

Lotte Chemical Corporation - Polycarbonate

General Information

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.41		ASTM D792
Density (Natural)	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	30	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	30	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	1.5E-3 to 3.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	2.0E-3 to 3.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.20 to 0.30	%	
Flow : 0.0787 in	0.15 to 0.30	%	
Ash Content			
--	25	%	ASTM D5630
--	25	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	683000	psi	ASTM D638
Tensile Modulus	696000	psi	ISO 527-1/5
Tensile Strength ² (Yield)	9250	psi	ASTM D638
Tensile Stress (Yield)	9430	psi	ISO 527-2/5
Tensile Strength ² (Break)	9390	psi	ASTM D638
Tensile Stress (Break)	9570	psi	ISO 527-2/5
Tensile Elongation ² (Break)	2.8	%	ASTM D638
Tensile Strain (Break)	2.8	%	ISO 527-2/5
Flexural Modulus ³	853000	psi	ASTM D790
Flexural Modulus ⁴	870000	psi	ISO 178
Flexural Strength ³	15600	psi	ASTM D790
Flexural Stress ⁴	16000	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
73°F, 0.125 in	0.73	ft-lb/in	
73°F, 0.250 in	0.73	ft-lb/in	
Notched Izod Impact Strength ⁵ (73°F)	1.9	ft-lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	219	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	212	°F	
Vicat Softening Temperature	232	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.06 to 0.12 in)	V-0		UL 94

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°F
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	428 to 446	°F
Middle Temperature	446 to 500	°F
Front Temperature	464 to 536	°F
Nozzle Temperature	482 to 536	°F
Mold Temperature	104 to 212	°F
Injection Pressure	7110 to 35600	psi
Back Pressure	71.1 to 427	psi
Screw Speed	50 to 200	rpm

Injection Notes

Hot Runner Temperature: 280°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