Infino NH-3150F

Lotte Chemical Corporation - Polycarbonate

General Information	
General	
Filler / Reinforcement	• Glass Fiber

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.31		ASTM D792
Density (Natural)	1.31	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	35	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	35	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	2.0E-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	0.20 to 0.30	%	
Ash Content	15	%	ASTM D5630
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus [2]	711000	psi	ASTM D638
Tensile Modulus	696000	psi	ISO 527-1/5
Tensile Strength [2] (Yield)	16400	psi	ASTM D638
Tensile Stress (Yield)	14500	psi	ISO 527-2/5
Tensile Strength [2] (Break)	16400	psi	ASTM D638
Tensile Stress (Break)	14500	psi	ISO 527-2/5
Tensile Elongation [2] (Break)	3.0	%	ASTM D638
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus [3]	754000	psi	ASTM D790
Flexural Modulus [4]	725000	psi	ISO 178
Flexural Strength [3]	23500	psi	ASTM D790
Flexural Stress [4]	21800	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	1.7	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	0.73	ft·lb/in	
73°F, 0.250 in	0.64	ft·lb/in	
Notched Izod Impact Strength [5] (73°F)	1.9	ft·lb/in²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	210	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	208	°F	

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Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.04 in	V-1		
0.06 in	V-0		

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	0.040	%
Rear Temperature	446 to 482	°F
Middle Temperature	464 to 500	°F
Front Temperature	482 to 518	°F
Nozzle Temperature	500	°F
Mold Temperature	140 to 176	°F
Injection Pressure	14200	psi
Back Pressure	71.1 to 356	psi
Screw Speed	50 to 200	rpm

Injection Notes

Hot Runner Temperature: 250 to 270°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