

# Infino CF-3300HF

Lotte Chemical Corporation - Polycarbonate

## General Information

### General

Filler / Reinforcement	• Glass Fiber
RoHS Compliance	• RoHS Compliant

## Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.40		ASTM D792
Density (Natural)	1.40	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	22	g/10 min	
300°C/1.2 kg	11	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	22	g/10 min	
300°C/1.2 kg	11	g/10 min	
Molding Shrinkage - Flow (0.126 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	925000	psi	ASTM D638
Tensile Modulus	1.00E+6	psi	ISO 527-1/5
Tensile Strength <sup>2</sup> (Yield)	17100	psi	ASTM D638
Tensile Stress (Yield)	18100	psi	ISO 527-2/5
Tensile Strength <sup>2</sup> (Break)	17100	psi	ASTM D638
Tensile Stress (Break)	18100	psi	ISO 527-2/5
Tensile Elongation <sup>2</sup> (Break)	3.8	%	ASTM D638
Tensile Strain (Break)	3.6	%	ISO 527-2/5
Flexural Modulus <sup>3</sup>	939000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	1.06E+6	psi	ISO 178
Flexural Strength <sup>3</sup>	24200	psi	ASTM D790
Flexural Stress <sup>4</sup>	26100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	8.6	ft-lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.4	ft-lb/in	
73°F, 0.250 in	2.8	ft-lb/in	
Notched Izod Impact Strength <sup>5</sup> (73°F)	8.1	ft-lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Rockwell Hardness (R-Scale)	115		ISO 2039-2

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<b>Thermal</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	289	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	289	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	284	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	280	°F	ISO 75-2/A
Vicat Softening Temperature			
--	295	°F	ISO 306/B120
--	289	°F	ISO 306/B50

<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
0.031 in	V-2		
0.13 in	V-1		

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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	°F
Nozzle Temperature	590	°F
Mold Temperature	176 to 248	°F
Injection Pressure	14200	psi
Back Pressure	145 to 421	psi
Screw Speed	40 to 80	rpm

**Injection Notes**  
Hot Runner Temperature: 310°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