

Infino NH-3402F

Lotte Chemical Corporation - Polycarbonate

General Information

General

Filler / Reinforcement • Glass Fiber

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.51		ASTM D792
Density (Natural)	1.51	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	33	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	33	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.10 to 0.40	%	
Flow : 0.0787 in	0.10 to 0.40	%	
Water Absorption (Saturation, 73°F)	0.15	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	1.42E+6	psi	ASTM D638
Tensile Modulus	1.45E+6	psi	ISO 527-1/5
Tensile Strength ² (Yield)	20300	psi	ASTM D638
Tensile Stress (Yield)	26700	psi	ISO 527-2/5
Tensile Strength ² (Break)	24500	psi	ASTM D638
Tensile Stress (Break)	26100	psi	ISO 527-2/5
Tensile Elongation ² (Break)	3.2	%	ASTM D638
Tensile Strain (Break)	3.2	%	ISO 527-2/5
Flexural Modulus ³	1.56E+6	psi	ASTM D790
Flexural Modulus ⁴	1.74E+6	psi	ISO 178
Flexural Strength ³	25600	psi	ASTM D790
Flexural Stress ⁴	36300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	8.1	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	2.1	ft-lb/in	
73°F, 0.250 in	1.8	ft-lb/in	
Notched Izod Impact Strength ⁵ (73°F)	7.6	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Rockwell Hardness (R-Scale)	122		ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	243	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	252	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	230	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	237	°F	ISO 75-2/A
Vicat Softening Temperature	244	°F	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.08 in	V-1		
0.10 in	V-0		
0.12 in	V-0		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	230	°F
Hot Air Dryer	248	°F
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.030	%
Rear Temperature	464 to 482	°F
Middle Temperature	500 to 518	°F
Front Temperature	536 to 545	°F
Nozzle Temperature	554	°F
Mold Temperature	212	°F
Injection Pressure	9960 to 32700	psi
Back Pressure	71.1 to 284	psi
Screw Speed	30 to 70	rpm

Injection Notes
Hot Runner Temperature: 290°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