

Infino HN-1064

Lotte Chemical Corporation - Polycarbonate

General Information

General

RoHS Compliance • RoHS Compliant

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.18		ASTM D792
Density (Natural)	1.18	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	38	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	38	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.70	%	
Flow : 0.0787 in	0.40 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	292000	psi	ASTM D638
Tensile Modulus	305000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	8390	psi	ASTM D638
Tensile Stress (Yield)	8410	psi	ISO 527-2/50
Tensile Strength ² (Break)	9100	psi	ASTM D638
Tensile Stress (Break)	9140	psi	ISO 527-2/50
Tensile Elongation ² (Break)	93	%	ASTM D638
Tensile Strain (Break)	100	%	ISO 527-2/50
Flexural Modulus ³	299000	psi	ASTM D790
Flexural Modulus ⁴	319000	psi	ISO 178
Flexural Strength ³	11900	psi	ASTM D790
Flexural Stress ⁴	12300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	28	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	11	ft·lb/in	
73°F, 0.250 in	3.4	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	25	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Rockwell Hardness (R-Scale)	119		ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	279	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	273	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	262	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	259	°F	ISO 75-2/A
Vicat Softening Temperature	284	°F	ISO 306/B50
RTI Elec (0.06 in)	266	°F	UL 746B
RTI Imp (0.06 in)	266	°F	UL 746B
RTI Str (0.06 in)	266	°F	UL 746B

Flammability	Nominal Value	Unit	Test Method
Flame Rating 0.030 in	V-2		UL 94
0.05 in	V-1		
0.06 in	V-0		
0.12 in	V-0		

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	2.0 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 590	°F
Nozzle Temperature	554 to 590	°F
Mold Temperature	104 to 212	°F
Injection Pressure	7110 to 35600	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 290 to 310°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 in/min

³ 0.11 in/min

⁴ 0.079 in/min

⁵ 4mm