

Infino HF-3200H

Lotte Chemical Corporation - Polycarbonate

General Information

General

Filler / Reinforcement • Glass Fiber

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.37		ASTM D792
Density (Natural)	1.37	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	11	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	11	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-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 ²	711000	psi	ASTM D638
Tensile Modulus	740000	psi	ISO 527-1/5
Tensile Strength ² (Yield)	15600	psi	ASTM D638
Tensile Stress (Yield)	16000	psi	ISO 527-2/5
Tensile Strength ² (Break)	15600	psi	ASTM D638
Tensile Stress (Break)	16700	psi	ISO 527-2/5
Tensile Elongation ² (Break)	4.3	%	ASTM D638
Tensile Strain (Break)	3.7	%	ISO 527-2/5
Flexural Modulus ³	782000	psi	ASTM D790
Flexural Modulus ⁴	841000	psi	ISO 178
Flexural Strength ³	21300	psi	ASTM D790
Flexural Stress ⁴	24700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	6.7	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	2.8	ft-lb/in	ASTM D256
Notched Izod Impact Strength ⁵ (73°F)	5.5	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	293	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	293	°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	284	°F	ISO 75-2/A

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature			
--	302	°F	ISO 306/B120
--	297	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.06 in	V-2		
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	2.0 to 4.0	hr
Hot Air Dryer	4.0 to 6.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	482 to 500	°F
Middle Temperature	500 to 518	°F
Front Temperature	536 to 545	°F
Nozzle Temperature	545	°F
Mold Temperature	158 to 212	°F
Injection Pressure	9960 to 32700	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	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