Infino HN-3207

Lotte Chemical Corporation - Polycarbonate

General Information

General

Filler / Reinforcement	• Glass Fiber

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.35		ASTM D792
Density (Natural)	1.35	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	9.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	9.0	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.20 to 0.50	%	
Flow : 0.0787 in	0.20 to 0.50	%	
Ash Content			
--	20	%	ASTM D5630
--	20	%	ISO 3451

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus [2]	782000	psi	ASTM D638
Tensile Modulus	798000	psi	ISO 527-1/5
Tensile Strength [2] (Yield)	12100	psi	ASTM D638
Tensile Stress (Yield)	12800	psi	ISO 527-2/5
Tensile Strength [2] (Break)	12200	psi	ASTM D638
Tensile Stress (Break)	12500	psi	ISO 527-2/5
Tensile Elongation [2] (Break)	4.0	%	ASTM D638
Tensile Strain (Break)	4.0	%	ISO 527-2/5
Flexural Modulus [3]	782000	psi	ASTM D790
Flexural Modulus [4]	783000	psi	ISO 178
Flexural Strength [3]	21300	psi	ASTM D790
Flexural Stress [4]	21800	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength [5] (73°F)	3.3	ft·lb/in²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	1.3	ft·lb/in	ASTM D256
Notched Izod Impact Strength [5] (73°F)	3.3	ft·lb/in²	ISO 180/1A

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Rockwell Hardness (R-Scale)	119		ISO 2039-2

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	280	°F	

Infino HN-3207

Lotte Chemical Corporation - Polycarbonate

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	279	°F	

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

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	212	°F
Hot Air Dryer	212	°F
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	536 to 554	°F
Middle Temperature	554 to 572	°F
Front Temperature	572 to 590	°F
Nozzle Temperature	572 to 590	°F
Mold Temperature	176 to 212	°F
Injection Pressure	14200	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

Injection Notes

Hot Runner Temperature: 300 to 310°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