

Infino HA-4302G

Lotte Chemical Corporation - Polyphthalamide

General Information

General

Filler / Reinforcement	• Glass Fiber
Uses	• Automotive Under the Hood

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.34		ASTM D792
Density (Natural)	1.34	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	5.0	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)	5.0E-3 to 8.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.50 to 0.80	%	
Flow : 0.0787 in	0.30 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Break)	23500	psi	ASTM D638
Tensile Stress (Break)	23900	psi	ISO 527-2/5
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ³	1.14E+6	psi	ASTM D790
Flexural Modulus ⁴	1.09E+6	psi	ISO 178
Flexural Strength ³	32700	psi	ASTM D790
Flexural Stress ⁴	31900	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	6.2	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	2.1	ft·lb/in	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	125		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	536	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	536	°F	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	248	°F
Hot Air Dryer	212	°F

Infino HA-4302G

Lotte Chemical Corporation - Polyphthalamide

Injection	Nominal Value	Unit
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	6.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	572 to 590	°F
Middle Temperature	590 to 608	°F
Front Temperature	608 to 626	°F
Nozzle Temperature	626	°F
Mold Temperature	212 to 248	°F
Injection Pressure	14200	psi
Back Pressure	71.1 to 427	psi
Screw Speed	100 to 150	rpm

Injection Notes

Hot Runner Temperature: 320 to 330°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