Infino HX-4300G

Lotte Chemical Corporation - Polyphthalamide

General Information	
General	
Filler / Reinforcement	• Glass Fiber
Uses	• Electrical/Electronic Applications

Properties [1]			
Physical	**Nominal Value**	**Unit**	**Test Method**
Density / Specific Gravity (Natural)	1.45		ASTM D792
Density (Natural)	1.45	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	25	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	25	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
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [2] (Break)	24200	psi	ASTM D638
Tensile Stress (Break)	24700	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]	1.42E+6	psi	ASTM D790
Flexural Modulus [4]	1.54E+6	psi	ISO 178
Flexural Strength [3]	31300	psi	ASTM D790
Flexural Stress [4]	30500	psi	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [5] (73°F)	4.8	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	1.2	ft·lb/in	
73°F, 0.250 in	1.3	ft·lb/in	
Notched Izod Impact Strength [5] (73°F)	3.9	ft·lb/in²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	122		ASTM D785
Rockwell Hardness (R-Scale)	122		ISO 2039-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	554	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	554	°F	
Electrical	**Nominal Value**	**Unit**	**Test Method**
Comparative Tracking Index (CTI)	PLC 1		IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.02 to 0.12 in)	V-0		UL 94

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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	4.0 to 6.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	536 to 554	°F
Middle Temperature	572 to 590	°F
Front Temperature	608 to 626	°F
Nozzle Temperature	626	°F
Mold Temperature	212 to 284	°F
Injection Pressure	15600	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm
Injection Notes		
Hot Runner Temperature: 320°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