

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	22	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	22	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0049	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.005	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2100	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Stress at break	96	MPa	ISO 527
Strain at break	102	%	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	88	MPa	ISO 178
Charpy notched impact strength, +23°C	68	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	63	kJ/m ²	ISO 180/1A
Rockwell hardness	R 120	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1900	MPa	ASTM D 638
Tensile Strength at Yield	59	MPa	ASTM D 638
Tensile Strength at Break	69	MPa	ASTM D 638
Elongation at Break	120	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	83	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	690	J/m	ASTM D 256
Izod Impact notched, 1/4 in	540	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	120	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	133	°C	ISO 75-1/-2
Vicat softening temperature, B	140	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	126	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1180	kg/m ³	ISO 1183
Density	1180	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	300	°C	-
Mold temperature	80 - 100	°C	-
Zone 1	270	°C	-
Zone 2	280	°C	-
Zone 3	290	°C	-
Nozzle temperature	300	°C	-

INFINO HF-1023IM

PC

Lotte Chemical Corporation

Screw speed	40 - 80	rpm	-
Injection pressure	98	MPa	-
Back pressure	1 - 2.9	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color