

INFINO HA-1011

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	49	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
ASTM Data			
Melt Flow Index, MFI	49	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	1900	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	130	%	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	73	MPa	ISO 178
Charpy notched impact strength, +23°C	45	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	54	kJ/m ²	ISO 180/1A
Rockwell hardness	R 104	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1800	MPa	ASTM D 638
Tensile Strength at Yield	46	MPa	ASTM D 638
Tensile Strength at Break	59	MPa	ASTM D 638
Elongation at Break	115	%	ASTM D 638
Flexural Modulus	1900	MPa	ASTM D 790
Flexural Strength	69	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785
Izod Impact notched, 1/8 in	710	J/m	ASTM D 256
Izod Impact notched, 1/4 in	390	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	98	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	120	°C	ISO 75-1/-2
Vicat softening temperature, B	117	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	127	°C	ASTM D 648
DTUL @ 264 psi	106	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1130	kg/m ³	ISO 1183
Water Absorption, Equilibrium	0.15	%	ASTM D 570
Density	1130	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.05	%	-
Melt temperature	260	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	220 - 230	°C	-
Zone 2	240 - 250	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	270	°C	-
Screw speed	50 - 150	rpm	-

INFINO HA-1011

(PC+ABS)

Lotte Chemical Corporation

Injection pressure	88	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color