

**INFINO HP-1000XA**

(PC+ABS)

Lotte Chemical Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	27	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	27	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	50	MPa	ISO 527
Stress at break	53	MPa	ISO 527
Strain at break	100	%	ISO 527
Flexural modulus, 23°C	2100	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	49	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	45	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 113	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	2000	MPa	ASTM D 638
Tensile Strength at Yield	54	MPa	ASTM D 638
Tensile Strength at Break	59	MPa	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	74	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	590	J/m	ASTM D 256
Izod Impact notched, 1/4 in	440	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	102	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	123	°C	ISO 75-1/-2
Vicat softening temperature, B	123	°C	ISO 306
<b>ASTM Data</b>			
DTUL @ 264 psi	110	°C	ASTM D 648
<b>Other properties</b>			
Density	1130	kg/m <sup>3</sup>	ISO 1183
Density	1130	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	210 - 230	°C	-
Zone 2	230 - 250	°C	-
Zone 3	250 - 265	°C	-
Nozzle temperature	250 - 280	°C	-

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Screw speed	<b>50 - 80</b>	rpm	-
Injection pressure	<b>150</b>	MPa	-
Back pressure	<b>0.5 - 2.5</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets, Natural Color

**Applications**

Automotive

**Regional Availability**

North America, Europe, Asia Pacific