

**INFINO HP-1000XB**

(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	<b>5.1</b>	g/10min	ISO 1133
Temperature	<b>250</b>	°C	-
Load	<b>2.16</b>	kg	-
Molding shrinkage, parallel	<b>0.6</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.6</b>	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>5.1</b>	g/10min	ASTM D 1238
Temperature	<b>250</b>	°C	-
Load	<b>2.16</b>	kg	-
Mold Shrinkage, MD	<b>0.0055</b>	mm/mm	ASTM D 955
Mold Shrinkage, TD	<b>0.0055</b>	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	<b>2100</b>	MPa	ISO 527
Yield stress	<b>58</b>	MPa	ISO 527
Stress at break	<b>59</b>	MPa	ISO 527
Strain at break	<b>100</b>	%	ISO 527
Flexural modulus, 23°C	<b>2100</b>	MPa	ISO 178
Flexural strength	<b>82</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>50</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	<b>44</b>	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	<b>R 115</b>	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	<b>2000</b>	MPa	ASTM D 638
Tensile Strength at Yield	<b>57</b>	MPa	ASTM D 638
Tensile Strength at Break	<b>52</b>	MPa	ASTM D 638
Elongation at Break	<b>100</b>	%	ASTM D 638
Flexural Modulus	<b>2200</b>	MPa	ASTM D 790
Flexural Strength	<b>80</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 115</b>	-	ASTM D 785
Izod Impact notched, 1/4 in	<b>470</b>	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>103</b>	°C	ISO 75-1/-2
<b>ASTM Data</b>			
DTUL @ 264 psi	<b>111</b>	°C	ASTM D 648
<b>Other properties</b>			
Density	<b>1130</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1130</b>	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	<b>90 - 100</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>250 - 280</b>	°C	-
Mold temperature	<b>60 - 90</b>	°C	-
Zone 1	<b>210 - 230</b>	°C	-
Zone 2	<b>230 - 250</b>	°C	-
Zone 3	<b>250 - 265</b>	°C	-
Nozzle temperature	<b>250 - 280</b>	°C	-
Screw speed	<b>50 - 150</b>	rpm	-
Injection pressure	<b>150</b>	MPa	-
Back pressure	<b>0.5 - 2</b>	MPa	-

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### Characteristics

#### Processing

Injection Molding

#### Regional Availability

North America, Europe, Asia Pacific

#### Delivery form

Pellets, Natural Color