

INFINO HP-1000XD

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	32	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
ASTM Data			
Melt Flow Index, MFI	32	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
Mechanical properties			
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	65	MPa	ISO 527
Stress at break	60	MPa	ISO 527
Strain at break	80	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	98	MPa	ISO 178
Charpy notched impact strength, +23°C	48	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	44	kJ/m ²	ISO 180/1A
Rockwell hardness	R 113	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2200	MPa	ASTM D 638
Tensile Strength at Yield	65	MPa	ASTM D 638
Tensile Strength at Break	59	MPa	ASTM D 638
Elongation at Break	80	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	91	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	520	J/m	ASTM D 256
Izod Impact notched, 1/4 in	150	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	110	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	127	°C	ISO 75-1/-2
Vicat softening temperature, B	125	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	128	°C	ASTM D 648
DTUL @ 264 psi	115	°C	ASTM D 648
Other properties			
Value			
Density	1160	kg/m ³	ISO 1183
Density	1160	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value			
Pre-drying - Temperature	90	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.04	%	-
Melt temperature	240 - 260	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	230 - 250	°C	-
Zone 2	240 - 260	°C	-
Zone 3	240 - 260	°C	-

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Nozzle temperature	250	°C	-
Screw speed	50 - 80	rpm	-
Injection pressure	69	MPa	-
Back pressure	4.9 - 7.8	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color