

INFINO HP-1000XG

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	37	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	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	2300	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Stress at break	80	MPa	ISO 527
Strain at break	80	%	ISO 527
Flexural modulus, 23°C	2500	MPa	ISO 178
Flexural strength	95	MPa	ISO 178
Charpy notched impact strength, +23°C	50	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	15	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	40	kJ/m ²	ISO 180/1A
Rockwell hardness	R 120	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2300	MPa	ASTM D 638
Tensile Strength at Yield	64	MPa	ASTM D 638
Tensile Strength at Break	66	MPa	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	2400	MPa	ASTM D 790
Flexural Strength	88	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	540	J/m	ASTM D 256
Izod Impact notched, 1/4 in	150	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	130	J/m	ASTM D 256
Temperature	-30	°C	-
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	109	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	125	°C	ISO 75-1/-2
Vicat softening temperature, B	130	°C	ISO 306
Coeff. of linear therm. expansion, parallel	74	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	80	E-6/K	ISO 11359-1/-2
ASTM Data			
Coefficient of Thermal Expansion, MD	74	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	80	E-6/K	ASTM D 696
DTUL @ 66 psi	129	°C	ASTM D 648
DTUL @ 264 psi	115	°C	ASTM D 648
Other properties			
Water absorption	0.1	%	Sim. to ISO 62
Density	1150	kg/m ³	ISO 1183
Density	1150	kg/m ³	ASTM D 792

INFINO HP-1000XG

(PC+ABS)

Lotte Chemical Corporation

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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	-
Screw speed	50 - 80	rpm	-
Injection pressure	69	MPa	-
Back pressure	0.5 - 2.5	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color