

INFINO HP-1000XL

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	4.7	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	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	4.7	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	2.16	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	2000	MPa	ISO 527
Yield stress	55	MPa	ISO 527
Stress at break	55	MPa	ISO 527
Strain at break	100	%	ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	83	MPa	ISO 178
Charpy notched impact strength, +23°C	52	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	52	kJ/m ²	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2000	MPa	ASTM D 638
Tensile Strength at Yield	57	MPa	ASTM D 638
Tensile Strength at Break	57	MPa	ASTM D 638
Elongation at Break	105	%	ASTM D 638
Flexural Modulus	2200	MPa	ASTM D 790
Flexural Strength	81	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact unnotched, 1/8 in	640	J/m	ASTM D 256
Izod Impact unnotched, 1/4 in	490	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	105	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	125	°C	ISO 75-1/-2
Vicat softening temperature, B	128	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	114	°C	ASTM D 648
Other properties			
Density	1140	kg/m ³	ISO 1183
Density	1140	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
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	50 - 150	rpm	-
Injection pressure	69	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color