INFINO HA-4302G

PPA-GF — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**5**	g/10min	ISO 1133
Temperature	**330**	°C	-
Load	**2.16**	kg	-
ASTM Data			
Melt Flow Index, MFI	**5**	g/10min	ASTM D 1238
Temperature	**330**	°C	-
Load	**2.16**	kg	-
Mold Shrinkage, MD	**0.005**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.006**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**9650**	MPa	ISO 527
Stress at break	**170**	MPa	ISO 527
Strain at break	**3.2**	%	ISO 527
Flexural modulus, 23°C	**7500**	MPa	ISO 178
Flexural strength	**220**	MPa	ISO 178
Charpy notched impact strength, +23°C	**13**	kJ/m²	ISO 179/1eA
ASTM Data			
Tensile Strength at Break	**170**	MPa	ASTM D 638
Flexural Modulus	**7800**	MPa	ASTM D 790
Flexural Strength	**230**	MPa	ASTM D 790
Izod Impact notched, 1/8 in	**110**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**280**	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 264 psi	**280**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1340**	kg/m³	ISO 1183
Density	**1340**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**100**	°C	-
Pre-drying - Time	**6**	h	-
Processing humidity	**≤0.05**	%	-
Melt temperature	**320 - 330**	°C	-
Mold temperature	**100 - 120**	°C	-
Zone 1	**300 - 310**	°C	-
Zone 2	**310 - 320**	°C	-
Zone 3	**320 - 330**	°C	-
Nozzle temperature	**330**	°C	-
Screw speed	**100 - 150**	rpm	-
Injection pressure	**98**	MPa	-
Back pressure	**0.5 - 2.9**	MPa	-

Characteristics

Processing

Injection Molding

Applications

Automotive

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific