INFINO HA-4350G

PPA-GF — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**17**	g/10min	ISO 1133
Temperature	**330**	°C	-
Load	**2.16**	kg	-
Molding shrinkage, parallel	**0.3**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.6**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**17**	g/10min	ASTM D 1238
Temperature	**330**	°C	-
Load	**2.16**	kg	-
Mold Shrinkage, MD	**0.0035**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.0055**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**215**	MPa	ISO 527
Stress at break	**215**	MPa	ISO 527
Strain at break	**4.2**	%	ISO 527
Flexural modulus, 23°C	**10500**	MPa	ISO 178
Flexural strength	**275**	MPa	ISO 178
Charpy notched impact strength, +23°C	**11**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**10**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 124**	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	**210**	MPa	ASTM D 638
Tensile Strength at Break	**210**	MPa	ASTM D 638
Elongation at Break	**4.1**	%	ASTM D 638
Flexural Modulus	**11000**	MPa	ASTM D 790
Flexural Strength	**270**	MPa	ASTM D 790
Rockwell Hardness	**R 124**	-	ASTM D 785

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**290**	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 264 psi	**290**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1470**	kg/m³	ISO 1183
Density	**1470**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**120**	°C	-
Pre-drying - Time	**4**	h	-
Processing humidity	**≤0.1**	%	-
Melt temperature	**330**	°C	-
Mold temperature	**130 - 140**	°C	-
Zone 1	**300**	°C	-
Zone 2	**305 - 310**	°C	-
Zone 3	**315 - 320**	°C	-
Nozzle temperature	**330**	°C	-
Screw speed	**140 - 150**	rpm	-
Injection pressure	**7.8**	MPa	-
Back pressure	**1**	MPa	-

Characteristics

Processing
Injection Molding

Applications
Automotive

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific