

INFINO HA-4350HP

PPA-GF

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.0045	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	200	MPa	ISO 527
Stress at break	200	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	11000	MPa	ISO 178
Flexural strength	250	MPa	ISO 178
Izod notched impact strength, +23°C	8.5	kJ/m ²	ISO 180/1A
Rockwell hardness	R 110	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	200	MPa	ASTM D 638
Tensile Strength at Break	200	MPa	ASTM D 638
Elongation at Break	3	%	ASTM D 638
Flexural Modulus	11000	MPa	ASTM D 790
Flexural Strength	250	MPa	ASTM D 790
Rockwell Hardness	R 110	-	ASTM D 785

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	1470	kg/m ³	ISO 1183
Density	1470	kg/m ³	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 - 130	°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

Delivery form

Pellets, Natural Color

Applications

Automotive

Regional Availability

North America, Europe, Asia Pacific