

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	25	g/10min	ISO 1133
Temperature	330	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	25	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	0.0085	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	10000	MPa	ISO 178
Flexural strength	250	MPa	ISO 178
Charpy notched impact strength, +23°C	8	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	8	kJ/m ²	ISO 180/1A
Rockwell hardness	R 120	-	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	9300	MPa	ASTM D 790
Flexural Strength	250	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
Izod Impact notched, 1/8 in	79	J/m	ASTM D 256
Izod Impact notched, 1/4 in	79	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	295	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.5	mm	-
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.8	mm	-
DTUL @ 264 psi	295	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Density	1410	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	320 - 240	°C	-
Mold temperature	120 - 140	°C	-
Zone 1	300 - 310	°C	-
Zone 2	310 - 320	°C	-

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PPA-GF

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Zone 3	320 - 340	°C	-
Nozzle temperature	320 - 340	°C	-
Screw speed	50 - 150	rpm	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color