

**INFINO HM-4500G**

PPA-GF

Lotte Chemical Corporation

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.3</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.6</b>	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Mold Shrinkage, MD	<b>0.0035</b>	mm/mm	ASTM D 955
Mold Shrinkage, TD	<b>0.0055</b>	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
<b>ISO Data</b>			
Yield stress	<b>250</b>	MPa	ISO 527
Stress at break	<b>250</b>	MPa	ISO 527
Strain at break	<b>3</b>	%	ISO 527
Flexural modulus, 23°C	<b>15000</b>	MPa	ISO 178
Flexural strength	<b>350</b>	MPa	ISO 178
Charpy notched impact strength, +23°C	<b>13</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	<b>13</b>	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	<b>R 120</b>	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength at Yield	<b>250</b>	MPa	ASTM D 638
Tensile Strength at Break	<b>250</b>	MPa	ASTM D 638
Elongation at Break	<b>3</b>	%	ASTM D 638
Flexural Modulus	<b>15000</b>	MPa	ASTM D 790
Flexural Strength	<b>340</b>	MPa	ASTM D 790
Rockwell Hardness	<b>R 120</b>	-	ASTM D 785
Izod Impact notched, 1/8 in	<b>130</b>	J/m	ASTM D 256
Izod Impact notched, 1/4 in	<b>130</b>	J/m	ASTM D 256
<b>Thermal properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	<b>240</b>	°C	ISO 75-1/-2
Burning behav. at thickness h	<b>HB</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8</b>	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	<b>HB</b>	-	UL 94
Thickness tested	<b>0.8</b>	mm	-
DTUL @ 264 psi	<b>240</b>	°C	ASTM D 648
<b>Other properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
Density	<b>1580</b>	kg/m <sup>3</sup>	ISO 1183
Density	<b>1580</b>	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
Pre-drying - Temperature	<b>100 - 120</b>	°C	-
Pre-drying - Time	<b>4</b>	h	-
Processing humidity	<b>≤0.05</b>	%	-
Melt temperature	<b>300 - 320</b>	°C	-
Mold temperature	<b>60 - 130</b>	°C	-
Zone 1	<b>260 - 270</b>	°C	-
Zone 2	<b>280 - 290</b>	°C	-
Zone 3	<b>290 - 310</b>	°C	-
Nozzle temperature	<b>290 - 310</b>	°C	-
Screw speed	<b>50 - 150</b>	rpm	-
Back pressure	<b>0.5 - 2</b>	MPa	-

**Characteristics**

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### Processing

Injection Molding

### Regional Availability

North America, Europe, Asia Pacific

### Delivery form

Pellets, Natural Color