

**INFINO HM-4650LW**

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	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.0025	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Yield stress	280	MPa	ISO 527
Stress at break	280	MPa	ISO 527
Strain at break	3	%	ISO 527
Flexural modulus, 23°C	20000	MPa	ISO 178
Flexural strength	390	MPa	ISO 178
Charpy notched impact strength, +23°C	15	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	15	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 120	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Strength at Yield	270	MPa	ASTM D 638
Tensile Strength at Break	270	MPa	ASTM D 638
Elongation at Break	3	%	ASTM D 638
Flexural Modulus	20000	MPa	ASTM D 790
Flexural Strength	380	MPa	ASTM D 790
Rockwell Hardness	R 120	-	ASTM D 785
<b>Thermal properties</b>			
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	245	°C	ISO 75-1/-2
<b>ASTM Data</b>			
DTUL @ 264 psi	245	°C	ASTM D 648
<b>Other properties</b>			
<b>Value</b>			
Density	1780	kg/m <sup>3</sup>	ISO 1183
Density	1780	kg/m <sup>3</sup>	ASTM D 792
<b>Processing Recommendation Injection Molding</b>			
<b>Value</b>			
Pre-drying - Temperature	100 - 120	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.05	%	-
Melt temperature	300	°C	-
Mold temperature	60 - 130	°C	-
Zone 1	260 - 270	°C	-
Zone 2	280 - 290	°C	-
Zone 3	290 - 300	°C	-
Nozzle temperature	290 - 300	°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