

INFINO HA-4400MP

PPA-MF

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4	%	ISO 294-4, 2577
ASTM Data			
Mold Shrinkage, MD	0.002	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.004	mm/mm	ASTM D 955
Mechanical properties			
ISO Data	Value	Unit	Test Standard
Yield stress	175	MPa	ISO 527
Stress at break	175	MPa	ISO 527
Strain at break	4	%	ISO 527
Flexural modulus, 23°C	9000	MPa	ISO 178
Flexural strength	240	MPa	ISO 178
Charpy notched impact strength, +23°C	10	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	10	kJ/m ²	ISO 180/1A
Rockwell hardness	R 100	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	170	MPa	ASTM D 638
Tensile Strength at Break	170	MPa	ASTM D 638
Elongation at Break	4	%	ASTM D 638
Flexural Modulus	8800	MPa	ASTM D 790
Flexural Strength	240	MPa	ASTM D 790
Rockwell Hardness	R 100	-	ASTM D 785
Izod Impact notched, 1/8 in	98	J/m	ASTM D 256
Izod Impact notched, 1/4 in	98	J/m	ASTM D 256
Thermal properties			
ISO Data	Value	Unit	Test Standard
Temp. of deflection under load, 1.80 MPa	275	°C	ISO 75-1/-2
ASTM Data			
DTUL @ 264 psi	275	°C	ASTM D 648
Other properties			
Value	Unit	Test Standard	
Density	1440	kg/m ³	ISO 1183
Density	1440	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value	Unit	Test Standard	
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.2	%	-
Melt temperature	330	°C	-
Mold temperature	120 - 150	°C	-
Zone 1	310 - 330	°C	-
Zone 2	320 - 330	°C	-
Zone 3	320 - 330	°C	-
Nozzle temperature	320	°C	-
Screw speed	200 - 250	rpm	-
Injection pressure	69 - 150	MPa	-
Back pressure	0.5 - 1	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific