

<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt flow index, MFI	23	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.5	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Melt Flow Index, MFI	23	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0045	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	60	MPa	ISO 527
Flexural modulus, 23°C	3000	MPa	ISO 178
Flexural strength	95	MPa	ISO 178
Charpy notched impact strength, +23°C	27	kJ/m <sup>2</sup>	ISO 179/1eA
Izod notched impact strength, +23°C	27	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	R 116	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	3200	MPa	ASTM D 638
Tensile Strength at Yield	59	MPa	ASTM D 638
Tensile Strength at Break	41	MPa	ASTM D 638
Elongation at Break	15	%	ASTM D 638
Flexural Modulus	2900	MPa	ASTM D 790
Flexural Strength	93	MPa	ASTM D 790
Rockwell Hardness	R 116	-	ASTM D 785
Izod Impact notched, 1/8 in	280	J/m	ASTM D 256
Izod Impact unnotched, 1/4 in	200	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	141	°C	ISO 75-1/-2
Vicat softening temperature, B	137	°C	ISO 306
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
<b>ASTM Data</b>			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	0.8	mm	-
DTUL @ 264 psi	141	°C	ASTM D 648

<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Water absorption	0.3	%	Sim. to ISO 62
Density	1250	kg/m <sup>3</sup>	ISO 1183
Water Absorption, Equilibrium	0.3	%	ASTM D 570
Density	1250	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	100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.05	%	-
Melt temperature	290	°C	-
Mold temperature	80 - 120	°C	-
Zone 1	270	°C	-
Zone 2	280 - 290	°C	-

**INFINO CF-3104HF**

PC-GF

Lotte Chemical Corporation

Zone 3	<b>300</b>	°C	-
Nozzle temperature	<b>300</b>	°C	-
Screw speed	<b>50 - 150</b>	rpm	-
Injection pressure	<b>98</b>	MPa	-
Back pressure	<b>0.5 - 2</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific

**Delivery form**

Pellets, Natural Color