INFINO HN-3204

PC-GF — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**9**	g/10min	ISO 1133
Temperature	**300**	°C	-
Load	**1.2**	kg	-
ASTM Data			
Melt Flow Index, MFI	**9**	g/10min	ASTM D 1238
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Mold Shrinkage, MD	**0.0035**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.0035**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**5500**	MPa	ISO 527
Yield stress	**88**	MPa	ISO 527
Stress at break	**86**	MPa	ISO 527
Strain at break	**4**	%	ISO 527
Flexural modulus, 23°C	**5400**	MPa	ISO 178
Flexural strength	**150**	MPa	ISO 178
Charpy notched impact strength, +23°C	**7**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**7**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 119**	-	ISO 2039-2
ASTM Data			
Tensile Modulus	**5400**	MPa	ASTM D 638
Tensile Strength at Yield	**83**	MPa	ASTM D 638
Tensile Strength at Break	**84**	MPa	ASTM D 638
Elongation at Break	**4**	%	ASTM D 638
Flexural Modulus	**5400**	MPa	ASTM D 790
Flexural Strength	**150**	MPa	ASTM D 790
Rockwell Hardness	**R 119**	-	ASTM D 785
Izod Impact notched, 1/8 in	**69**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**137**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**142**	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	**V-0**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Burning behav. at thickness h	**V-0**	class	IEC 60695-11-10
Thickness tested	**3.0**	mm	-
Burning behav. 5V at thickness h	**5VA**	class	IEC 60695-11-20
Thickness tested	**2.5**	mm	-
Glow Wire Flammability Index (GWFI)	**960**	°C	IEC 60695-2-12
GWFI - thickness tested (1)	**1.5**	mm	-
Glow Wire Flammability Index (GWFI)	**960**	°C	IEC 60695-2-12
GWFI - thickness tested (2)	**3**	mm	-
Glow Wire Ignition Temperature (GWIT)	**825**	°C	IEC 60695-2-13
GWIT - thickness tested (1)	**1.5**	mm	-
ASTM Data			
UL 94 Flame rating	**V-0**	-	UL 94
Thickness tested	**1.5**	mm	-
DTUL @ 66 psi	**143**	°C	ASTM D 648
DTUL @ 264 psi	**138**	°C	ASTM D 648

Electrical properties	Value	Unit	Test Standard
ISO Data			
Comparative tracking index	**210**	-	IEC 60112

Other properties	Value	Unit	Test Standard
Density	**1350**	kg/m³	ISO 1183
Density	**1350**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**100**	°C	-
Pre-drying - Time	**4**	h	-
Processing humidity	**≤0.05**	%	-
Melt temperature	**300 - 310**	°C	-
Mold temperature	**80 - 100**	°C	-
Zone 1	**280 - 290**	°C	-
Zone 2	**290 - 300**	°C	-
Zone 3	**300 - 310**	°C	-
Nozzle temperature	**300 - 310**	°C	-
Screw speed	**50 - 150**	rpm	-
Injection pressure	**98**	MPa	-
Back pressure	**0.5 - 2**	MPa	-

Characteristics

Processing
Injection Molding

Regional Availability
North America, Europe, Asia Pacific

Delivery form
Pellets, Natural Color