

INFINO HP-1000XC

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	4	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	4	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	60	MPa	ISO 527
Stress at break	61	MPa	ISO 527
Strain at break	100	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	90	MPa	ISO 178
Charpy notched impact strength, +23°C	60	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	55	kJ/m ²	ISO 180/1A
Rockwell hardness	R 118	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2400	MPa	ASTM D 638
Tensile Strength at Yield	59	MPa	ASTM D 638
Tensile Strength at Break	59	MPa	ASTM D 638
Elongation at Break	105	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	88	MPa	ASTM D 790
Rockwell Hardness	R 118	-	ASTM D 785
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256
Izod Impact notched, 1/4 in	540	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	102	°C	ISO 75-1/-2
Vicat softening temperature, B	124	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	111	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1170	kg/m ³	ISO 1183
Density	1170	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	230 - 250	°C	-
Zone 2	240 - 260	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	250 - 280	°C	-
Screw speed	50 - 150	rpm	-

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Injection pressure	150	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color