Infino HP-1000XC

Polycarbonate + ABS

LOTTE ADVANCED MATERIALS CO., LTD.

Technical Data

Product Description
Infino HP-1000XC is a Polycarbonate + ABS (PC+ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General			
Material Status	• Commercial: Active		
Literature [1]	• Processing (English) • Technical Information - ASTM (English) • Technical Information - ISO (English)		
Search for UL Yellow Card	• LOTTE ADVANCED MATERIALS CO., LTD. • Infino		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.17	g/cm³	ASTM D792 ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	4.0	g/10 min	ASTM D1238 ISO 1133
Molding Shrinkage			
Flow : 3.20 mm	0.40 to 0.70	%	ASTM D955
Across Flow : 3.20 mm	0.40 to 0.70	%	ASTM D955
Across Flow : 2.00 mm	0.40 to 0.70	%	ISO 294-4
Flow : 2.00 mm	0.40 to 0.70	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [3]	2400	MPa	ASTM D638
--	2200	MPa	ISO 527-2/50
Tensile Strength			
Yield [3]	59.0	MPa	ASTM D638
Yield	60.0	MPa	ISO 527-2/50
Break [3]	59.0	MPa	ASTM D638
Break	61.0	MPa	ISO 527-2/50
Tensile Elongation			
Break [3]	110	%	ASTM D638
Break	100	%	ISO 527-2/50
Flexural Modulus			
-- [4]	2300	MPa	ASTM D790
-- [5]	2400	MPa	ISO 178
Flexural Strength			
-- [4]	88.0	MPa	ASTM D790
-- [5]	90.0	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength [6] (23°C)	60	kJ/m²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	640	J/m	ASTM D256
23°C, 6.35 mm	540	J/m	ASTM D256
23°C [6]	55	kJ/m²	ISO 180/1A
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	118		ASTM D785 ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	111	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	102	°C	ISO 75-2/A
Vicat Softening Temperature	124	°C	ISO 306/B50

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	90 to 100	°C
Hot Air Dryer	90 to 100	°C
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	2.0 to 4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	230 to 250	°C
Middle Temperature	240 to 260	°C
Front Temperature	260 to 270	°C
Nozzle Temperature	250 to 280	°C
Mold Temperature	60 to 90	°C
Injection Pressure	147	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

Injection Notes
Hot Runner Temperature: 250 to 280°C

Notes

[1] These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.

[2] Typical properties: these are not to be construed as specifications.

[3] 50 mm/min

[4] 10 mm/min

[5] 2.0 mm/min

[6] 4mm

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