

# Infino HA-4350G

LOTTE ADVANCED MATERIALS CO., LTD. - Polyphthalamide

Saturday, January 18, 2020

## General Information

General			
Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber		

## ASTM & ISO Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.47	g/cm <sup>3</sup>	ASTM D792
Density (Natural)	1.47	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	17	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	17	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.50	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.40 to 0.70	%	
Flow : 2.00 mm	0.20 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	206	MPa	ASTM D638
Tensile Stress (Yield)	215	MPa	ISO 527-2/5
Tensile Strength <sup>2</sup> (Break)	206	MPa	ASTM D638
Tensile Stress (Break)	215	MPa	ISO 527-2/5
Tensile Elongation <sup>2</sup> (Break)	4.1	%	ASTM D638
Tensile Strain (Break)	4.2	%	ISO 527-2/5
Flexural Modulus <sup>3</sup>	10800	MPa	ASTM D790
Flexural Modulus <sup>4</sup>	10500	MPa	ISO 178
Flexural Strength <sup>3</sup>	275	MPa	ASTM D790
Flexural Stress <sup>4</sup>	275	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (23°C)	11	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
23°C, 3.18 mm	74	J/m	
23°C, 6.35 mm	74	J/m	
Notched Izod Impact Strength <sup>5</sup> (23°C)	10	kJ/m <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	124		ASTM D785
Rockwell Hardness (R-Scale)	124		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	290	°C	
Heat Deflection Temperature			ISO 75-2/A
1.8 MPa, Unannealed, 4.00 mm	290	°C	

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## LOTTE ADVANCED MATERIALS CO., LTD. - Polyphthalamide

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	120	°C
Hot Air Dryer	120	°C
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	300	°C
Middle Temperature	305 to 310	°C
Front Temperature	315 to 320	°C
Nozzle Temperature	330	°C
Mold Temperature	130 to 140	°C
Injection Pressure	7.85	MPa
Back Pressure	0.981	MPa
Screw Speed	140 to 150	rpm

### Injection Notes

Hot Runner Temperature: 330°C

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 5.0 mm/min

<sup>3</sup> 2.8 mm/min

<sup>4</sup> 2.0 mm/min

<sup>5</sup> 4mm