

Infino HA-4302G

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 ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.34	g/cm ³	ASTM D792
Density (Natural)	1.34	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (330°C/2.16 kg)	5.0	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.35 to 0.65	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.55 to 0.85	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Flexural Modulus ²	7800	MPa	ASTM D790
Flexural Modulus ³	7500	MPa	ISO 178
Flexural Strength ²	230	MPa	ASTM D790
Flexural Stress ³	220	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁴ (23°C)	13	kJ/m ²	ISO 179/1eA
Notched Izod Impact (23°C, 3.18 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 1.8 MPa, Unannealed, 6.40 mm	280	°C	ASTM D648
Heat Deflection Temperature 1.8 MPa, Unannealed, 4.00 mm	280	°C	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	120	°C
Hot Air Dryer	100	°C
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	6.0	hr
Suggested Max Moisture	0.050	%
Rear Temperature	300 to 310	°C
Middle Temperature	310 to 320	°C
Front Temperature	320 to 330	°C
Nozzle Temperature	330	°C
Mold Temperature	100 to 120	°C
Injection Pressure	98.1	MPa

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Injection	Nominal Value	Unit
Back Pressure	0.490 to 2.94	MPa
Screw Speed	100 to 150	rpm

Injection Notes

Hot Runner Temperature: 320 to 330°C

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.8 mm/min

³ 2.0 mm/min

⁴ 4mm