

Infino HA-4350HP

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)	1.47	g/cm ³	ASTM D792
Density (Natural)	1.47	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.20 mm)	0.30 to 0.60	%	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	0.30 to 0.60	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	200	MPa	ASTM D638
Tensile Stress (Yield)	200	MPa	ISO 527-2/5
Tensile Strength ² (Break)	200	MPa	ASTM D638
Tensile Stress (Break)	200	MPa	ISO 527-2/5
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ³	11000	MPa	ASTM D790
Flexural Modulus ⁴	11000	MPa	ISO 178
Flexural Strength ³	250	MPa	ASTM D790
Flexural Stress ⁴	250	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵ (23°C)	8.5	kJ/m ²	ISO 180/1A

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	280	°C	
Heat Deflection Temperature			ISO 75-2/A
1.8 MPa, Unannealed, 4.00 mm	280	°C	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	100	°C
Hot Air Dryer	100	°C

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Injection	Nominal Value	Unit
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 130	°C
Injection Pressure	98.1	MPa
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 5.0 mm/min

³ 2.8 mm/min

⁴ 2.0 mm/min

⁵ 4mm