

Infino HA-1011

Polycarbonate + ABS
SAMSUNG SDI CO., LTD.

Message:
Infino HA-1011 is a Polycarbonate + ABS (PC+ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General Information			
UL YellowCard	E115797-100692271		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	49	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.40	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.15	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	110		ASTM D785
R-Scale	104		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1800	MPa	ASTM D638
--	1900	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	46.0	MPa	ASTM D638
Yield	50.0	MPa	ISO 527-2/50
Break ³	59.0	MPa	ASTM D638
Break	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	120	%	ASTM D638
Break	130	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	1900	MPa	ASTM D790
-- ⁶	2000	MPa	ISO 178
Flexural Strength			
-- ⁷	69.0	MPa	ASTM D790
-- ⁸	73.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	45	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	710	J/m	ASTM D256

23°C, 6.35 mm	390	J/m	ASTM D256
23°C ¹⁰	54	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	127	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	120	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	106	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	98.0	°C	ISO 75-2/A
Vicat Softening Temperature			
--	117	°C	ISO 306/B50
--	118	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature			
--	80.0 to 100	°C	
Desiccant Dryer	80.0 to 100	°C	
Drying Time			
--	4.0 to 6.0	hr	
Desiccant Dryer	2.0 to 4.0	hr	
Suggested Max Moisture	< 0.050	%	
Rear Temperature	220 to 230	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	260 to 270	°C	
Nozzle Temperature	270	°C	
Mold Temperature	50.0 to 70.0	°C	
Injection Pressure	88.3	MPa	
Back Pressure	0.490 to 1.96	MPa	
Screw Speed	50 to 150	rpm	
NOTE			
1.	50 mm/min		
2.	5.0 mm/min		
3.	50 mm/min		
4.	50 mm/min		
5.	2.8 mm/min		
6.	2.0 mm/min		
7.	2.8 mm/min		
8.	2.0 mm/min		
9.	Thickness: 4 mm		
10.	Thickness: 4 mm		

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