

Infino XI-4208

Polyamide
SAMSUNG SDI CO., LTD.

Message:
Infino XI-4208 is a Polyamide product filled with glass fiber. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General Information			
Filler / Reinforcement	Glass Fiber		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.80	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	30	g/10 min	ASTM D1238, ISO 1133
Water Absorption			
23°C, 24 hr	0.30	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.30	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
Yield ¹	66.0	MPa	ASTM D638
Yield	67.0	MPa	ISO 527-2/5
Flexural Modulus			
-- ²	6100	MPa	ASTM D790
-- ³	5800	MPa	ISO 178
Flexural Strength			
-- ⁴	110	MPa	ASTM D790
-- ⁵	107	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁶ (23°C)	3.5	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	39	J/m	ASTM D256
23°C ⁷	4.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 6.40 mm	135	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	135	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity ⁸	1.0E+14	ohms	ASTM D257, IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature			
--	120	°C	

Desiccant Dryer	120	°C
Drying Time		
--	2.0 to 6.0	hr
Desiccant Dryer	2.0 to 4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	250 to 260	°C
Middle Temperature	270 to 280	°C
Front Temperature	290 to 300	°C
Nozzle Temperature	300	°C
Mold Temperature	60.0 to 120	°C
Injection Pressure	49.0 to 245	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

NOTE

- | | |
|----|-----------------|
| 1. | 5.0 mm/min |
| 2. | 2.8 mm/min |
| 3. | 2.0 mm/min |
| 4. | 2.8 mm/min |
| 5. | 2.0 mm/min |
| 6. | Thickness: 4 mm |
| 7. | Thickness: 4 mm |
| 8. | 23°C, 50% RH |

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