

Infino HP-1000XA

Polycarbonate + ABS

SAMSUNG SDI CO., LTD.

Message:

PC/ABS material for automobile IP-core

General Information			
UL YellowCard	E115797-219634		
Uses	Automotive Applications		
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)	27	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.49 to 0.59	%	
Across Flow : 3.20 mm	0.51 to 0.62	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	113		ASTM D785
R-Scale	112		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2000	MPa	ASTM D638
--	2000	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	54.0	MPa	ASTM D638
Yield	50.0	MPa	ISO 527-2/50
Break ³	59.0	MPa	ASTM D638
Break	53.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	100	%	ASTM D638
Break	100	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2000	MPa	ASTM D790
-- ⁶	2100	MPa	ISO 178
Flexural Strength			
-- ⁷	74.0	MPa	ASTM D790
-- ⁸	80.0	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	490	J/m	ASTM D256
23°C, 6.35 mm	440	J/m	ASTM D256
23°C ¹⁰	45	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 4.00 mm	123	°C	ISO 75-2/B
0.45 MPa, Annealed	125	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	110	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	102	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	112	°C	ISO 75-2/A
Vicat Softening Temperature			
--	123	°C	ISO 306/B50
--	125	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature			
--	90.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	4.0	hr	
Desiccant Dryer	4.0	hr	
Suggested Max Moisture	0.040	%	
Rear Temperature	230 to 250	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	250	°C	
Mold Temperature	50.0 to 70.0	°C	
Injection Pressure	147	MPa	
Back Pressure	0.490 to 2.45	MPa	
Screw Speed	50 to 80	rpm	
NOTE			
1.	50 mm/min		
2.	50 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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