

Infino HI-1001BP

Polycarbonate + ABS
SAMSUNG SDI CO., LTD.

Message:
PC/ABS material for plating

General Information			
UL YellowCard		E115797-219626	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	32	g/10 min	ASTM D1238, ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2100	MPa	ASTM D638
--	2000	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	54.0	MPa	ASTM D638
Yield	55.0	MPa	ISO 527-2/50
Break ³	56.0	MPa	ASTM D638
Break	40.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	110	%	ASTM D638
Break	74	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2100	MPa	ASTM D790
-- ⁶	2000	MPa	ISO 178
Flexural Strength			
-- ⁷	78.0	MPa	ASTM D790
-- ⁸	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	47	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	560	J/m	ASTM D256
23°C, 6.35 mm	430	J/m	ASTM D256
23°C ¹⁰	52	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			

0.45 MPa, Unannealed, 6.40 mm	121	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	113	°C	ISO 75-2/B
0.45 MPa, Annealed	117	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	102	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	93.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	103	°C	ISO 75-2/A
Vicat Softening Temperature	110	°C	ISO 306/B50

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	58.8	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	50 mm/min	
4.	50 mm/min	
5.	10 mm/min	
6.	2.0 mm/min	
7.	10 mm/min	
8.	2.0 mm/min	
9.	Thickness: 4 mm	
10.	Thickness: 4 mm	

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