



INFINO®	Grade	WR-0790HF
	Resin Type	

Item	Measuring Method	Condition	Unit	Value
Physical				
Specific Gravity	ISO 1183	Natural or representative	-	1.05
Melt Flow Index	ISO 1133	200°C, 5kg	g/10min	5.0
Mold Shrinkage(MD)	ISO 294-4	Flow at 2mm(MD)	%	0.3-0.6
Mold Shrinkage(TD)	ISO 294-4	X-Flow at 2mm(TD)	%	0.3-0.6
Mechanical				
Tensile Strength at Yield	ISO 527	50mm/min	MPa	43
Tensile Strain at break	ISO 527	50mm/min	%	-
Tensile Modulus	ISO 527	50mm/min	MPa	-
Tensile Strength at Break	ISO 527	50mm/min	MPa	-
Flexural Strength	ISO 178	2mm/min	MPa	78
Flexural Modulus	ISO 178	2mm/min	MPa	2700
Izod Impact Strength (notched)	ISO 180 1A	at 23°C, 4mm	kJ/m ²	15
Izod 충격강도(unnotched)	ISO 180 1A	at 23°C, 4mm	kJ/m ²	-
Charpy Impact Strength (V-notched)	ISO 179 1eA	at 23°C, 4mm	kJ/m ²	18
Rockwell Hardness	ISO 2039-2	R-scale	-	110
Thermal properties				
Heat Deflection Temperature(Unannealed)	ISO 75-2	1.8MPa, 4.0mm	°C	-
Heat Deflection Temperature(Unannealed)	ISO 75-2	0.45MPa, 4.0mm	°C	-
VICAT Softening Temperature	ISO 306	B/50	°C	93

1. The above figures are the representative values based on NP, which may vary from color to color, and can be used as a reference only for the purpose of selecting materials.
2. The above figures are basic guidelines for selecting materials; therefore, they are not regarded as the official specifications for materials involved, and cannot be used for the purpose of designing a mold.
3. The above values can be adjusted in accordance with processing conditions, and the specific change in value is allowed only within a limited range in which adjustment has no adverse or negative impact on the final product.

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* The last update date : 2022/01/04

Processing Guide

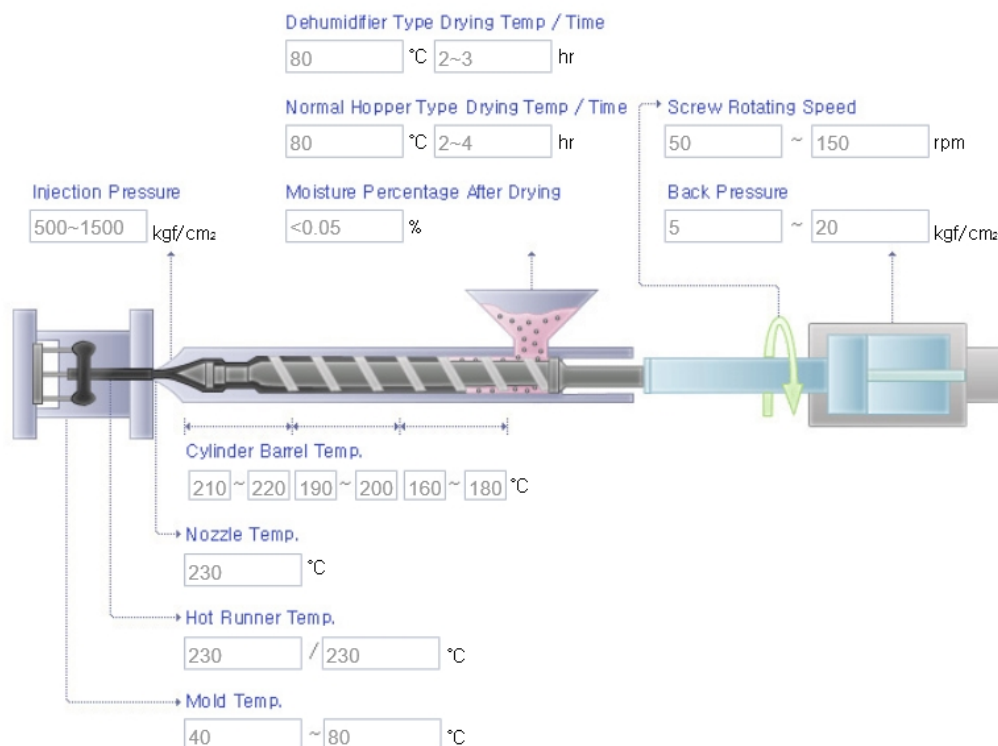
INFINO

Grade

WR-0790HF

Resin Type

Item		Unit	Representative	
Mold Temp.(Standard Molding)	Stationary Platen	℃	40 ~ 80	
	Moving Platen			
Hot Runner Temp.	Manifolder	℃	230	
	Valve Nozzle		230	
Nozzle Temp.		℃	230	
Cylinder Barrel Temp.	Front Part	℃	210 ~ 220	
	Mid Part		190 ~ 200	
	Rear Part		160 ~ 180	
Injection Pressure		kgf/cm ²	500~1500	
Drying Condition	Dehumidifier Type	Drying Temp	℃	80
		Drying Time	hr	2~3
	Normal Hopper Type	Drying Temp	℃	80
		Drying Time	hr	2~4
Moisture Percentage After Drying		%	<0.05	
Screw Rotating Speed		rpm	50 ~ 150	
MPa		kgf/cm ²	5 ~ 20	



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