

TECHNICAL DATA SHEET

INFINO WP-1041G

Lotte Chemical Corporation
 (PC+ABS)

Processing

Injection molding

Delivery Form

Pellets, Natural color

Applications

Automotive

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	3	g/10min	ISO 1133
Temperature	250	°C	
Load	2.16	kg	
Molding shrinkage, parallel	0.55	%	ISO 294-4, 2577
Molding shrinkage, normal	0.55	%	ISO 294-4, 2577
Melt flow index, MFI	31	g/10min	ASTM D 1238
Temperature	250	°C	
Load	10	kg	
Mold shrinkage, MD	0.0055	mm/mm	ASTM D 955
Mold shrinkage, TD	0.0055	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Tensile modulus	1900	MPa	ISO 527
Yield stress	47	MPa	ISO 527
Stress at break	41	MPa	ISO 527
Strain at break	73	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	47	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	45	kJ/m ²	ISO 180/1A
Izod notched impact strength	35	kJ/m ²	ISO 180/1A
Temperature	-30	°C	
Rockwell hardness	R 107		ISO 2039-2

INFINO WP-1041G

Lotte Chemical Corporation

Mechanical Properties	Value	Unit	Standard
Tensile modulus	1900	MPa	ASTM D 638
Tensile strength at yield	49	MPa	ASTM D 638
Tensile strength at break	39	MPa	ASTM D 638
Elongation at break	100	%	ASTM D 638
Flexural modulus	1900	MPa	ASTM D 790
Flexural strength	66	MPa	ASTM D 790
Rockwell hardness	R 105		ASTM D 785
Izod impact notched, 1/8 in	540	J/m	ASTM D 256
Izod impact notched, 1/4 in	410	J/m	ASTM D 256
Izod impact notched, Low-Temperature	390	J/m	ASTM D 256
Temperature	-30	°C	
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	101	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	116	°C	ISO 75-1/-2
Vicat softening temperature, B	113	°C	ISO 306
Coeff. of linear therm. expansion, parallel	85	E-6/K	ISO 11359-1/-2
Coefficient of thermal expansion, MD	85	E-6/K	ASTM D 696
DTUL @ 66 psi	120	°C	ASTM D 648
DTUL @ 264 psi	100	°C	ASTM D 648
Other Properties	Value	Unit	Standard
Density	1090	kg/m ³	ISO 1183
Density	1090	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	90 - 100	°C	
Pre-drying - time	2 - 4	h	
Processing humidity	≤0.02	%	
Melt temperature	240 - 270	°C	
Mold temperature	60 - 90	°C	
Zone 1	210 - 230	°C	
Zone 2	230 - 240	°C	
Zone 3	240 - 265	°C	
Nozzle temperature	240 - 270	°C	

INFINO WP-1041G

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Processing Recommendation Injection Molding	Value	Unit	Standard
Screw speed	50 - 150	rpm	
Injection pressure	78	MPa	
Back pressure	0.5 - 2	MPa	