

TECHNICAL DATA SHEET

INFINO WP-1069

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	47	g/10min	ISO 1133
Temperature	250	°C	
Load	10	kg	
Molding shrinkage, parallel	0.55	%	ISO 294-4, 2577
Molding shrinkage, normal	0.55	%	ISO 294-4, 2577
Melt flow index, MFI	47	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
Yield stress	52	MPa	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	82	MPa	ISO 178
Charpy notched impact strength, +23°C	48	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	44	kJ/m ²	ISO 180/1A
Rockwell hardness	R 113		ISO 2039-2
Tensile modulus	2000	MPa	ASTM D 638
Tensile strength at yield	57	MPa	ASTM D 638
Tensile strength at break	55	MPa	ASTM D 638
Elongation at break	80	%	ASTM D 638
Flexural modulus	2200	MPa	ASTM D 790

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Mechanical Properties	Value	Unit	Standard
Flexural strength	78	MPa	ASTM D 790
Rockwell hardness	R 113		ASTM D 785
Izod impact notched, 1/8 in	570	J/m	ASTM D 256
Izod impact notched, 1/4 in	420	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	105	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	125	°C	ISO 75-1/-2
Vicat softening temperature, B	123	°C	ISO 306
DTUL @ 264 psi	108	°C	ASTM D 648
Other Properties	Value	Unit	Standard
Density	1130	kg/m ³	ISO 1183
Density	1130	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	250 - 280	°C	
Mold temperature	60 - 90	°C	
Zone 1	210 - 230	°C	
Zone 2	230 - 250	°C	
Zone 3	250 - 265	°C	
Nozzle temperature	250 - 280	°C	
Screw speed	50 - 150	rpm	
Injection pressure	150	MPa	
Back pressure	0.5 - 2	MPa	