

TECHNICAL DATA SHEET

INFINO WP-1089

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
Tensile modulus	2100	MPa	ISO 527
Yield stress	52	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	60	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	51	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	46	kJ/m ²	ISO 180/1A
Izod notched impact strength	32	kJ/m ²	ISO 180/1A
Temperature	-30	°C	
Rockwell hardness	R 113		ISO 2039-2

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Mechanical Properties	Value	Unit	Standard
Tensile modulus	2100	MPa	ASTM D 638
Tensile strength at yield	53	MPa	ASTM D 638
Tensile strength at break	44	MPa	ASTM D 638
Elongation at break	80	%	ASTM D 638
Flexural modulus	2100	MPa	ASTM D 790
Flexural strength	76	MPa	ASTM D 790
Rockwell hardness	R 113		ASTM D 785
Izod impact notched, 1/8 in	590	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	107	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	126	°C	ISO 75-1/-2
Vicat softening temperature, B	126	°C	ISO 306
Coeff. of linear therm. expansion, parallel	81	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	83	E-6/K	ISO 11359-1/-2
Coefficient of thermal expansion, MD	81	E-6/K	ASTM D 696
Coefficient of thermal expansion, TD	83	E-6/K	ASTM D 696
DTUL @ 66 psi	130	°C	ASTM D 648
DTUL @ 264 psi	110	°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	

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Processing Recommendation Injection Molding	Value	Unit	Standard
Zone 3	250 - 265	°C	
Nozzle temperature	250 - 280	°C	
Screw speed	50 - 80	rpm	
Injection pressure	59	MPa	
Back pressure	0.5 - 2.5	MPa	