

TECHNICAL DATA SHEET

INFINO SC-1220R

Lotte Chemical Corporation
 PC

Processing

Injection molding

Delivery Form

Pellets, Natural color

Applications

Electrical and electrical

Processing/Physical Characteristics	Value	Unit	Standard
Melt flow index, MFI	22	g/10min	ISO 1133
Temperature	300	°C	
Load	1.2	kg	
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
Melt flow index, MFI	22	g/10min	ASTM D 1238
Temperature	300	°C	
Load	1.2	kg	
Mold shrinkage, MD	0.006	mm/mm	ASTM D 955
Mold shrinkage, TD	0.006	mm/mm	ASTM D 955
Mechanical Properties	Value	Unit	Standard
Tensile modulus	2300	MPa	ISO 527
Yield stress	64	MPa	ISO 527
Stress at break	64	MPa	ISO 527
Strain at break	110	%	ISO 527
Poisson's ratio	0.35		ISO 527
Flexural modulus, 23°C	2300	MPa	ISO 178
Flexural strength	92	MPa	ISO 178
Charpy notched impact strength, +23°C	60	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	65	kJ/m ²	ISO 180/1A
Rockwell hardness	R 120		ISO 2039-2
Tensile modulus	2300	MPa	ASTM D 638
Tensile strength at yield	63	MPa	ASTM D 638

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Mechanical Properties	Value	Unit	Standard
Tensile strength at break	63	MPa	ASTM D 638
Elongation at break	110	%	ASTM D 638
Flexural modulus	2300	MPa	ASTM D 790
Flexural strength	90	MPa	ASTM D 790
Rockwell hardness	R 120		ASTM D 785
Izod impact notched, 1/8 in	740	J/m	ASTM D 256
Izod impact notched, 1/4 in	98	J/m	ASTM D 256
Thermal Properties	Value	Unit	Standard
Temp. of deflection under load, 1.80 MPa	123	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	136	°C	ISO 75-1/-2
Vicat softening temperature, B	145	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	V-2	class	IEC 60695-11-10
Thickness tested	1.5	mm	
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.75	mm	
UL 94 flame rating	V-2		UL 94
Thickness tested	0.75	mm	
DTUL @ 66 psi	136	°C	ASTM D 648
DTUL @ 264 psi	125	°C	ASTM D 648
Electrical Properties	Value	Unit	Standard
Dielectric constant, 1 MHz	2.9		ASTM D 150
Optical Properties	Value	Unit	Standard
Haze	0.8	%	ASTM D 1003
Light transmittance	89	%	ASTM D 1003
Other Properties	Value	Unit	Standard
Density	1200	kg/m ³	ISO 1183
Density	1200	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding	Value	Unit	Standard
Pre-drying - temperature	100	°C	
Pre-drying - time	5 - 6	h	
Processing humidity	≤0.05	%	

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Processing Recommendation Injection Molding	Value	Unit	Standard
Melt temperature	290	°C	
Mold temperature	80 - 110	°C	
Zone 1	250 - 280	°C	
Zone 2	260 - 290	°C	
Zone 3	270 - 300	°C	
Screw speed	10 - 20	rpm	
Injection pressure	69 - 130	MPa	
Back pressure	5.9 - 8.8	MPa	