

# Infino CF-1070

Lotte Chemical Corporation - Polycarbonate

## General Information

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	

## Properties<sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.20		ASTM D792
Density (Natural)	1.20	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	13	g/10 min	
300°C/1.2 kg	8.0	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	13	g/10 min	
300°C/1.2 kg	8.0	g/10 min	
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.70	%	
Flow : 0.0787 in	0.40 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	284000	psi	ASTM D638
Tensile Modulus	290000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	8530	psi	ASTM D638
Tensile Stress (Yield)	8410	psi	ISO 527-2/50
Tensile Strength <sup>2</sup> (Break)	8530	psi	ASTM D638
Tensile Stress (Break)	8700	psi	ISO 527-2/50
Tensile Elongation <sup>2</sup> (Break)	100	%	ASTM D638
Tensile Strain (Break)	100	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	284000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	305000	psi	ISO 178
Flexural Strength <sup>3</sup>	12100	psi	ASTM D790
Flexural Stress <sup>4</sup>	11600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	33	ft-lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	13	ft-lb/in	
73°F, 0.250 in	10	ft-lb/in	
Notched Izod Impact Strength <sup>5</sup> (73°F)	31	ft-lb/in <sup>2</sup>	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	284	°F	ISO 306/B50

## Infino CF-1070

### Lotte Chemical Corporation - Polycarbonate

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.031 in		V-2	
0.10 in		V-2	
0.12 in		V-2	

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	212	°F
Hot Air Dryer	212	°F
Drying Time		
Desiccant Dryer	2.0 to 4.0	hr
Hot Air Dryer	4.0 to 6.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	527 to 545	°F
Middle Temperature	545 to 563	°F
Front Temperature	563 to 581	°F
Nozzle Temperature	572	°F
Mold Temperature	158 to 212	°F
Injection Pressure	14200	psi
Back Pressure	142 to 427	psi
Screw Speed	40 to 80	rpm

#### Injection Notes

Hot Runner Temperature: 300°C

#### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 2.0 in/min

<sup>3</sup> 0.11 in/min

<sup>4</sup> 0.079 in/min

<sup>5</sup> 4mm