

Infino GM-1080

Lotte Chemical Corporation - Polycarbonate

General Information

General

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

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.20		ASTM D792
Density (Natural)	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	28	g/10 min	
300°C/1.2 kg	16	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	28	g/10 min	
300°C/1.2 kg	16	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 ²	284000	psi	ASTM D638
Tensile Modulus	290000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	8530	psi	ASTM D638
Tensile Stress (Yield)	8700	psi	ISO 527-2/50
Tensile Strength ² (Break)	8530	psi	ASTM D638
Tensile Stress (Break)	10200	psi	ISO 527-2/50
Tensile Elongation ² (Break)	100	%	ASTM D638
Tensile Strain (Break)	100	%	ISO 527-2/50
Flexural Modulus ³	284000	psi	ASTM D790
Flexural Modulus ⁴	290000	psi	ISO 178
Flexural Strength ³	11400	psi	ASTM D790
Flexural Stress ⁴	11600	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	28	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	13	ft-lb/in	
73°F, 0.250 in	11	ft-lb/in	
Notched Izod Impact Strength ⁵ (73°F)	25	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Rockwell Hardness (R-Scale)	116		ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.252 in	275	°F	ASTM D648
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	266	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	257	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	239	°F	ISO 75-2/A
Vicat Softening Temperature	282	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.031 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	< 0.10	%
Rear Temperature	518 to 536	°F
Middle Temperature	536 to 554	°F
Front Temperature	554 to 572	°F
Nozzle Temperature	572	°F
Mold Temperature	176 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

¹ Typical properties: these are not to be construed as specifications.

² 2.0 in/min

³ 0.11 in/min

⁴ 0.079 in/min

⁵ 4mm