

Infino QC-1220UR
Lotte Chemical Corporation - Polycarbonate

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	257	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	253	°F	ISO 75-2/A
Vicat Softening Temperature	293	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating 0.031 in	V-2		UL 94
0.06 in	V-2		
0.13 in	V-2		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature Desiccant Dryer	248	°F
Hot Air Dryer	248	°F
Drying Time Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	122 to 176	°F
Middle Temperature	482 to 518	°F
Front Temperature	518 to 572	°F
Nozzle Temperature	572	°F
Mold Temperature	176 to 248	°F
Injection Pressure	925	psi
Back Pressure	142 to 284	psi
Screw Speed	120 to 130	rpm

Injection Notes

Hot Runner Temperature: 290 to 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