HK:+852-69575415 China GuangDong:+13538586433 ShangHai:+18816996168

Infino GI-3103

Lotte Chemical Corporation - Polycarbonate

General Information

General

Filler / Reinforcement	• Glass Fiber

Properties [1]

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.25		ASTM D792
Density (Natural)	1.25	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	33	g/10 min	
300°C/1.2 kg	21	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	33	g/10 min	
300°C/1.2 kg	21	g/10 min	
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-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	0.30 to 0.60	%	

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus [2]	469000	psi	ASTM D638
Tensile Modulus	471000	psi	ISO 527-1/5
Tensile Strength [2] (Yield)	7970	psi	ASTM D638
Tensile Stress (Yield)	7690	psi	ISO 527-2/5
Tensile Strength [2] (Break)	8530	psi	ASTM D638
Tensile Stress (Break)	10200	psi	ISO 527-2/5
Tensile Elongation [2] (Break)	10	%	ASTM D638
Tensile Strain (Break)	10	%	ISO 527-2/5
Flexural Modulus [3]	455000	psi	ASTM D790
Flexural Modulus [3]	458000	psi	ISO 178
Flexural Strength [3]	12500	psi	ASTM D790
Flexural Stress [3]	12300	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength [4] (73°F)	9.0	ft·lb/in²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	4.3	ft·lb/in	
73°F, 0.250 in	3.0	ft·lb/in	
Notched Izod Impact Strength [4] (73°F)	8.6	ft·lb/in²	ISO 180/1A

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Rockwell Hardness (R-Scale)	115		ISO 2039-2

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	277	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	273	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	268	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	266	°F	
Vicat Softening Temperature	259	°F	ISO 306/B50

Electrical	Nominal Value	Unit	Test Method
Dielectric Constant (77°F)	2.90		ASTM D150
Relative Permittivity (77°F)	2.90		IEC 60250

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.031 in	HB		
0.13 in	HB		

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	500 to 518	°F
Middle Temperature	536 to 554	°F
Front Temperature	572 to 590	°F
Nozzle Temperature	590	°F
Mold Temperature	176 to 230	°F
Injection Pressure	14200	psi
Back Pressure	142 to 427	psi
Screw Speed	40 to 80	rpm

Injection Notes

Hot Runner Temperature: 300 to 320°C

Notes

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

[2] 0.20 in/min

[3] 0.11 in/min

[4] 4mm