

# Infino LS-3104G

Lotte Chemical Corporation - Polycarbonate

## General Information

General	
Filler / Reinforcement	• Glass Fiber
Uses	• LCD Applications

## Properties <sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.25		ASTM D792
Density (Natural)	1.25	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	30	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	30	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	2.0E-3 to 5.0E-3	in/in	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	475000	psi	ASTM D638
Tensile Strength <sup>2</sup> (Yield)	11400	psi	ASTM D638
Tensile Stress (Yield)	11600	psi	ISO 527-2/50
Tensile Strength <sup>2</sup> (Break)	11100	psi	ASTM D638
Tensile Elongation <sup>2</sup> (Break)	5.0	%	ASTM D638
Flexural Modulus <sup>3</sup>	540000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	551000	psi	ISO 178
Flexural Strength <sup>3</sup>	19900	psi	ASTM D790
Flexural Stress <sup>4</sup>	18900	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	2.9	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	1.5	ft·lb/in	
73°F, 0.250 in	1.1	ft·lb/in	

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ISO 2039-2

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	275	°F	
Vicat Softening Temperature	289	°F	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.030 in	V-2		
0.04 in	V-2		
0.12 in	V-2		

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## Lotte Chemical Corporation - Polycarbonate

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	230	°F
Hot Air Dryer	248	°F
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.030	%
Rear Temperature	464 to 482	°F
Middle Temperature	500 to 518	°F
Front Temperature	536 to 545	°F
Nozzle Temperature	554	°F
Mold Temperature	212	°F
Injection Pressure	9960 to 32700	psi
Back Pressure	71.1 to 284	psi
Screw Speed	30 to 70	rpm

### Injection Notes

Hot Runner Temperature: 290°C

### Notes

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

<sup>2</sup> 0.20 in/min

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

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

<sup>5</sup> 4mm