# Infino LT-1100

## Lotte Chemical Corporation - Polycarbonate

| General Information | |
|---|---|
| **General** | |
| Uses | • Automotive Applications |

| Properties [1] | | | |
|---|---|---|---|
| **Physical** | **Nominal Value** | **Unit** | **Test Method** |
| Density / Specific Gravity (Natural) | 1.19 | | ASTM D792 |
| Density (Natural) | 1.19 | g/cm³ | ISO 1183 |
| Melt Mass-Flow Rate (MFR) | | | ASTM D1238 |
| 250°C/10.0 kg | 25 | g/10 min | |
| 300°C/1.2 kg | 11 | g/10 min | |
| Melt Mass-Flow Rate (MFR) | | | ISO 1133 |
| 250°C/10.0 kg | 25 | g/10 min | |
| 300°C/1.2 kg | 11 | g/10 min | |
| Molding Shrinkage - Flow (0.126 in) | 5.0E-3 to 7.0E-3 | in/in | ASTM D955 |
| Molding Shrinkage - Across Flow (0.126 in) | 5.0E-3 to 7.0E-3 | in/in | ASTM D955 |
| Molding Shrinkage | | | ISO 294-4 |
| Across Flow : 0.0787 in | 0.50 to 0.70 | % | |
| Flow : 0.0787 in | 0.50 to 0.70 | % | |
| **Mechanical** | **Nominal Value** | **Unit** | **Test Method** |
| Tensile Modulus [2] | 320000 | psi | ASTM D638 |
| Tensile Modulus | 305000 | psi | ISO 527-1/50 |
| Tensile Strength [2] (Yield) | 9100 | psi | ASTM D638 |
| Tensile Stress (Yield) | 8990 | psi | ISO 527-2/50 |
| Tensile Strength [2] (Break) | 9390 | psi | ASTM D638 |
| Tensile Stress (Break) | 9280 | psi | ISO 527-2/50 |
| Tensile Elongation [2] (Break) | 110 | % | ASTM D638 |
| Tensile Strain (Break) | 110 | % | ISO 527-2/50 |
| Flexural Modulus [3] | 327000 | psi | ASTM D790 |
| Flexural Modulus [4] | 319000 | psi | ISO 178 |
| Flexural Strength [3] | 13100 | psi | ASTM D790 |
| Flexural Stress [4] | 13200 | psi | ISO 178 |
| **Impact** | **Nominal Value** | **Unit** | **Test Method** |
| Charpy Notched Impact Strength [5] (73°F) | 37 | ft·lb/in² | ISO 179/1eA |
| Notched Izod Impact | | | ASTM D256 |
| 73°F, 0.125 in | 16 | ft·lb/in | |
| 73°F, 0.250 in | 1.8 | ft·lb/in | |
| Notched Izod Impact Strength [5] (73°F) | 33 | ft·lb/in² | ISO 180/1A |
| **Hardness** | **Nominal Value** | **Unit** | **Test Method** |
| Rockwell Hardness (R-Scale) | 122 | | ASTM D785 |
| Rockwell Hardness (R-Scale) | 122 | | ISO 2039-2 |

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| Thermal | Nominal Value | Unit | Test Method |
|---|---|---|---|
| Deflection Temperature Under Load | | | ISO 75-2/B |
| 66 psi, Unannealed, 0.157 in | 279 | °F | |
| Deflection Temperature Under Load | | | ASTM D648 |
| 264 psi, Unannealed, 0.252 in | 262 | °F | |
| Deflection Temperature Under Load | | | ISO 75-2/A |
| 264 psi, Unannealed, 0.157 in | 255 | °F | |
| Vicat Softening Temperature | 289 | °F | ISO 306/B50 |

## Processing Information

| Injection | Nominal Value | Unit |
|---|---|---|
| Drying Temperature | | |
| Desiccant Dryer | 212 to 248 | °F |
| Hot Air Dryer | 212 to 248 | °F |
| Drying Time | | |
| Desiccant Dryer | 2.0 to 4.0 | hr |
| Hot Air Dryer | 1.0 to 2.0 | hr |
| Suggested Max Moisture | < 0.020 | % |
| Rear Temperature | 500 to 518 | °F |
| Middle Temperature | 518 to 554 | °F |
| Front Temperature | 554 to 572 | °F |
| Nozzle Temperature | 572 | °F |
| Mold Temperature | 140 to 194 | °F |
| Injection Pressure | 14200 | psi |
| Back Pressure | 71.1 to 356 | psi |
| Screw Speed | 50 to 100 | rpm |

**Injection Notes**

Hot Runner Temperature: 280 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