

# Infino LS-3302A

Lotte Chemical Corporation - Polycarbonate

## General Information

### General

Filler / Reinforcement	• Glass Fiber
Uses	• Camera Applications

## Properties<sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.41		ASTM D792
Density (Natural)	1.41	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	25	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	25	g/10 min	ISO 1133
Ash Content	31	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	827000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	14200	psi	ASTM D638
Tensile Stress (Yield)	14500	psi	ISO 527-2/50
Tensile Stress (Break)	15400	psi	ISO 527-2/50
Tensile Strain (Break)	3.0	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	839000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	856000	psi	ISO 178
Flexural Strength <sup>3</sup>	19900	psi	ASTM D790
Flexural Stress <sup>4</sup>	20300	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	7.6	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	2.8	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	5.7	ft·lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	293	°F	ISO 75-2/B
Deflection Temperature Under Load 66 psi, Annealed, 0.157 in	295	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.126 in	284	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	284	°F	ISO 75-2/A
Deflection Temperature Under Load 264 psi, Annealed, 0.157 in	286	°F	ISO 75-2/A
Vicat Softening Temperature			
--	304	°F	ISO 306/B120
--	298	°F	ISO 306/B50

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### Lotte Chemical Corporation - Polycarbonate

#### 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	°F
Middle Temperature	536 to 554	°F
Front Temperature	572	°F
Nozzle Temperature	572	°F
Mold Temperature	176 to 248	°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

<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