

Infino LS-3302

Lotte Chemical Corporation - Polycarbonate

General Information

General	
Filler / Reinforcement	• Glass Fiber
Uses	• Camera Applications

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.40		ASTM D792
Density (Natural)	1.40	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	12	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	12	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	957000	psi	ISO 527-1/5
Tensile Strength ² (Yield)	18500	psi	ASTM D638
Tensile Stress (Yield)	17400	psi	ISO 527-2/5
Tensile Strength ² (Break)	18500	psi	ASTM D638
Tensile Stress (Break)	17400	psi	ISO 527-2/5
Tensile Elongation ² (Break)	3.0	%	ASTM D638
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ³	1.07E+6	psi	ASTM D790
Flexural Modulus ⁴	1.20E+6	psi	ISO 178
Flexural Strength ³	25600	psi	ASTM D790
Flexural Stress ⁴	25400	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	5.7	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.2	ft·lb/in	
73°F, 0.250 in	2.2	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	5.7	ft·lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Rockwell Hardness (R-Scale)	120		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
66 psi, Unannealed, 0.252 in	291	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	291	°F	
Deflection Temperature Under Load			ASTM D648
264 psi, Unannealed, 0.252 in	284	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	284	°F	

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Thermal	Nominal Value	Unit	Test Method
Vicat Softening Temperature	300	°F	ISO 306/B50

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.031 in		V-2	
0.13 in		V-1	

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

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

² 0.20 in/min

³ 0.11 in/min

⁴ 0.079 in/min

⁵ 4mm