

Infino LS-3302L

Lotte Chemical Corporation - Polycarbonate

General Information

General

Filler / Reinforcement	• Glass Fiber
Uses	• Camera Applications

Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.41		ASTM D792
Density (Natural)	1.41	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	13	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	13	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	1.0E-3 to 4.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	3.0E-3 to 6.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.30 to 0.60	%	
Flow : 0.0787 in	0.10 to 0.40	%	
Ash Content			
--	30	%	ASTM D5630
--	30	%	ISO 3451
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	17100	psi	ASTM D638
Tensile Stress (Yield)	17400	psi	ISO 527-2/5
Tensile Strength ² (Break)	17100	psi	ASTM D638
Tensile Stress (Break)	17400	psi	ISO 527-2/5
Tensile Elongation ² (Break)	3.5	%	ASTM D638
Tensile Strain (Break)	3.5	%	ISO 527-2/5
Flexural Modulus ³	1.07E+6	psi	ASTM D790
Flexural Modulus ⁴	1.07E+6	psi	ISO 178
Flexural Strength ³	22800	psi	ASTM D790
Flexural Stress ⁴	23200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	10	ft·lb/in ²	ISO 179/1eA
Notched Izod Impact			ASTM D256
73°F, 0.125 in	3.0	ft·lb/in	
73°F, 0.250 in	2.8	ft·lb/in	
Notched Izod Impact Strength ⁵ (73°F)	9.5	ft·lb/in ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
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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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	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	7110 to 35600	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 0.079 in/min

⁵ 4mm