

# Infino GW-1029

Lotte Chemical Corporation - Polycarbonate

## General Information

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	

## Properties<sup>1</sup>

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.18		ASTM D792
Density (Natural)	1.18	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	19	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	19	g/10 min	ISO 1133
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield)	8390	psi	ASTM D638
Tensile Stress (Yield)	8700	psi	ISO 527-2/50
Flexural Modulus <sup>3</sup>	284000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	287000	psi	ISO 178
Flexural Strength <sup>3</sup>	11900	psi	ASTM D790
Flexural Stress <sup>4</sup>	11700	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	43	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.250 in)	10	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	31	ft·lb/in <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	116		ASTM D785
Rockwell Hardness (R-Scale)	116		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Unannealed, 0.252 in	255	°F	ASTM D648
Vicat Softening Temperature	282	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.031 in		HB	
0.06 in		HB	
0.12 in		HB	

## 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	2.0 to 6.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	464 to 482	°F

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### Lotte Chemical Corporation - Polycarbonate

Injection	Nominal Value	Unit
Middle Temperature	500 to 518	°F
Front Temperature	536 to 590	°F
Nozzle Temperature	554 to 590	°F
Mold Temperature	104 to 212	°F
Injection Pressure	7110 to 35600	psi
Back Pressure	71.1 to 284	psi
Screw Speed	50 to 150	rpm

#### Injection Notes

Hot Runner Temperature: 290 to 310°C

#### Notes

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

<sup>2</sup> 2.0 in/min

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

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

<sup>5</sup> 4mm