

# Infino LF-1025

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)	1.25		ASTM D792
Density (Natural)	1.25	g/cm <sup>3</sup>	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

Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	276000	psi	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	7780	psi	ASTM D638
Tensile Stress (Yield)	7540	psi	ISO 527-2/50
Tensile Stress (Break)	8120	psi	ISO 527-2/50
Tensile Strain (Break)	80	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	274000	psi	ASTM D790
Flexural Modulus <sup>4</sup>	290000	psi	ISO 178
Flexural Strength <sup>3</sup>	11600	psi	ASTM D790
Flexural Stress <sup>4</sup>	11600	psi	ISO 178

Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (73°F)	11	ft·lb/in <sup>2</sup>	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	5.1	ft·lb/in	ASTM D256
Notched Izod Impact Strength <sup>5</sup> (73°F)	10	ft·lb/in <sup>2</sup>	ISO 180/1A

Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ISO 2039-2

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 66 psi, Unannealed, 0.157 in	288	°F	ISO 75-2/B
Deflection Temperature Under Load 66 psi, Annealed, 0.157 in	288	°F	ISO 75-2/B
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	259	°F	ISO 75-2/A
Deflection Temperature Under Load 264 psi, Annealed, 0.157 in	264	°F	ISO 75-2/A
Vicat Softening Temperature --	302	°F	ISO 306/B120
--	298	°F	ISO 306/B50

## Processing Information

Injection	Nominal Value	Unit
Drying Temperature Desiccant Dryer	176	°F
Hot Air Dryer	176	°F

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### Lotte Chemical Corporation - Polycarbonate

Injection	Nominal Value	Unit
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	410 to 428	°F
Middle Temperature	446 to 464	°F
Front Temperature	482 to 536	°F
Nozzle Temperature	500 to 536	°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: 260 to 280°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