

Infino TP-1029

Lotte Chemical Corporation - Polycarbonate

General Information

General			
Uses	• Appliances		
Properties ¹			
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.20		ASTM D792
Density (Natural)	1.20	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage - Across Flow (0.126 in)	4.0E-3 to 7.0E-3	in/in	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 0.0787 in	0.40 to 0.70	%	
Flow : 0.0787 in	0.40 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	9100	psi	ASTM D638
Tensile Stress (Yield)	9140	psi	ISO 527-2/50
Flexural Modulus ³	313000	psi	ASTM D790
Flexural Modulus ⁴	328000	psi	ISO 178
Flexural Strength ³	12100	psi	ASTM D790
Flexural Stress ⁴	13100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	17	ft·lb/in	ASTM D256
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
264 psi, Unannealed, 0.252 in	261	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	257	°F	
Vicat Softening Temperature	288	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.03 to 0.12 in)	V-2		UL 94

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	230	°F
Hot Air Dryer	248	°F

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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	428 to 446	°F
Middle Temperature	464 to 536	°F
Front Temperature	500 to 572	°F
Nozzle Temperature	554	°F
Mold Temperature	104 to 248	°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°C

Notes

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

² 2.0 in/min

³ 0.11 in/min

⁴ 0.079 in/min