

Infino UF-1017S

Lotte Chemical Corporation - Polycarbonate

General Information

General

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

Properties¹

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) (220°C/10.0 kg)	19	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	19	g/10 min	ISO 1133
Molding Shrinkage - Flow (0.126 in)	3.0E-3 to 6.0E-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	0.30 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	341000	psi	ASTM D638
Tensile Modulus	319000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	8820	psi	ASTM D638
Tensile Stress (Yield)	8850	psi	ISO 527-2/50
Tensile Strength ² (Break)	8530	psi	ASTM D638
Tensile Stress (Break)	8990	psi	ISO 527-2/50
Tensile Elongation ² (Break)	70	%	ASTM D638
Tensile Strain (Break)	93	%	ISO 527-2/50
Flexural Modulus ³	334000	psi	ASTM D790
Flexural Modulus ⁴	341000	psi	ISO 178
Flexural Strength ³	12900	psi	ASTM D790
Flexural Stress ⁴	13100	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁵ (73°F)	32	ft-lb/in ²	ISO 179/1eA
Notched Izod Impact (73°F, 0.125 in)	12	ft-lb/in	ASTM D256
Notched Izod Impact Strength ⁵ (73°F)	30	ft-lb/in ²	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Rockwell Hardness (R-Scale)	119		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Unannealed, 0.157 in	219	°F	
Deflection Temperature Under Load			ISO 75-2/B
66 psi, Annealed, 0.157 in	226	°F	
Deflection Temperature Under Load			ISO 75-2/A
264 psi, Unannealed, 0.157 in	199	°F	

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Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 264 psi, Annealed, 0.157 in	221	°F	ISO 75-2/A
Vicat Softening Temperature			
--	234	°F	ISO 306/B120
--	228	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.016 in	V-2		
0.03 to 0.12 in	V-0		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	176	°F
Hot Air Dryer	176	°F
Drying Time		
Desiccant Dryer	2.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	0.040	%
Rear Temperature	482 to 500	°F
Middle Temperature	500 to 518	°F
Front Temperature	518 to 536	°F
Nozzle Temperature	536	°F
Mold Temperature	122 to 176	°F
Injection Pressure	14200	psi
Back Pressure	142 to 427	psi
Screw Speed	30 to 50	rpm

Injection Notes

Hot Runner Temperature: 280°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

⁵ 4mm