

Infino TH-1100

Lotte Chemical Corporation - Polycarbonate

General Information

General

Uses • Electrical/Electronic Applications

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) (250°C/10.0 kg)	17	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	17	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
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ²	284000	psi	ASTM D638
Tensile Modulus	290000	psi	ISO 527-1/50
Tensile Strength ² (Yield)	9250	psi	ASTM D638
Tensile Stress (Yield)	8700	psi	ISO 527-2/50
Tensile Strength ² (Break)	8530	psi	ASTM D638
Tensile Stress (Break)	7980	psi	ISO 527-2/50
Tensile Elongation ² (Break)	100	%	ASTM D638
Tensile Strain (Break)	92	%	ISO 527-2/50
Flexural Modulus ³	313000	psi	ASTM D790
Flexural Modulus ⁴	348000	psi	ISO 178
Flexural Strength ³	13700	psi	ASTM D790
Flexural Stress ⁴	13800	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (73°F, 0.125 in)	> 0.92	ft-lb/in	ASTM D256
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 264 psi, Unannealed, 0.252 in	266	°F	ASTM D648
Deflection Temperature Under Load 264 psi, Unannealed, 0.157 in	253	°F	ISO 75-2/A
Vicat Softening Temperature	291	°F	ISO 306/B50
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.08 in		V-0	
0.10 in		V-0	
0.12 in		V-0	

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Optical	Nominal Value	Unit	Test Method
Light Transmittance			
2500.0 mil	85.0	%	ASTM D1003
2500.0 mil	85.0	%	ISO 13468
Haze			
98.43 mil	2.00	%	ASTM D1003
98.43 mil	2.00	%	ISO 13468

Processing Information

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