

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	36	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	36	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.004	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	4300	MPa	ISO 527
Yield stress	109	MPa	ISO 527
Stress at break	109	MPa	ISO 527
Strain at break	3.9	%	ISO 527
Flexural modulus, 23°C	7400	MPa	ISO 178
Flexural strength	180	MPa	ISO 178
Charpy impact strength, +23°C	62	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	58	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	11	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	9	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	8	kJ/m ²	ISO 180/1A
Izod notched impact strength	7	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 111	-	ISO 2039-2
ASTM Data			
Tensile Modulus	4200	MPa	ASTM D 638
Tensile Strength at Yield	120	MPa	ASTM D 638
Tensile Strength at Break	120	MPa	ASTM D 638
Elongation at Break	3.5	%	ASTM D 638
Flexural Modulus	6100	MPa	ASTM D 790
Flexural Strength	150	MPa	ASTM D 790
Izod Impact notched, 1/8 in	69	J/m	ASTM D 256
Izod Impact notched, 1/4 in	79	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	59	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	121	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	131	°C	ISO 75-1/-2
Vicat softening temperature, B	130	°C	ISO 306
Coeff. of linear therm. expansion, parallel	3.1	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	6.4	E-6/K	ISO 11359-1/-2
ASTM Data			
Coefficient of Thermal Expansion, MD	3.1	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	6.4	E-6/K	ASTM D 696
DTUL @ 66 psi	138	°C	ASTM D 648
DTUL @ 264 psi	128	°C	ASTM D 648

Optical properties	Value	Unit	Test Standard
ISO Data			
Gloss, 60°	25	-	ISO 2813

INFINO WP-1200

(PC+ABS)-GF

Lotte Chemical Corporation

ASTM Data

Gloss	25	-	ASTM D 2457
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Other properties	Value	Unit	Test Standard
Density	1270	kg/m ³	ISO 1183
Density	1270	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90 - 110	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 290	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	220 - 240	°C	-
Zone 2	240 - 250	°C	-
Zone 3	250 - 270	°C	-
Nozzle temperature	250 - 290	°C	-
Screw speed	5 - 200	rpm	-
Injection pressure	98	MPa	-
Back pressure	0.5 - 2.9	MPa	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets, Natural Color

Applications

Automotive

Regional Availability

North America, Europe, Asia Pacific