

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	33	g/10min	ISO 1133
Temperature	250	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.5	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	33	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	10	kg	-
Mold Shrinkage, MD	0.0045	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0055	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	3250	MPa	ISO 527
Yield stress	53	MPa	ISO 527
Stress at break	70	MPa	ISO 527
Strain at break	10	%	ISO 527
Flexural modulus, 23°C	3160	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Charpy notched impact strength, +23°C	19	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	18	kJ/m ²	ISO 180/1A
Rockwell hardness	R 115	-	ISO 2039-2
ASTM Data			
Tensile Modulus	3200	MPa	ASTM D 638
Tensile Strength at Yield	55	MPa	ASTM D 638
Tensile Strength at Break	59	MPa	ASTM D 638
Elongation at Break	10	%	ASTM D 638
Flexural Modulus	3100	MPa	ASTM D 790
Flexural Strength	86	MPa	ASTM D 790
Rockwell Hardness	R 115	-	ASTM D 785
Izod Impact notched, 1/8 in	230	J/m	ASTM D 256
Izod Impact notched, 1/4 in	160	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	130	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	134	°C	ISO 75-1/-2
Vicat softening temperature, B	126	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.8	mm	-
DTUL @ 66 psi	136	°C	ASTM D 648
DTUL @ 264 psi	131	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1250	kg/m ³	ISO 1183
Density	1250	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.1	%	-
Melt temperature	300 - 320	°C	-

INFINO GI-3103

PC-GF

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Mold temperature	80 - 110	°C	-
Zone 1	260 - 270	°C	-
Zone 2	280 - 290	°C	-
Zone 3	300 - 310	°C	-
Nozzle temperature	310	°C	-
Screw speed	40 - 80	rpm	-
Injection pressure	98	MPa	-
Back pressure	1 - 2.9	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color