INFINO EN-1052

PC — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**19**	g/10min	ISO 1133
Temperature	**250**	°C	-
Load	**10**	kg	-
Molding shrinkage, parallel	**0.6**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.6**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**19**	g/10min	ASTM D 1238
Temperature	**250**	°C	-
Load	**10**	kg	-
Mold Shrinkage, MD	**0.0055**	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	**2100**	MPa	ISO 527
Yield stress	**55**	MPa	ISO 527
Stress at break	**67**	MPa	ISO 527
Strain at break	**109**	%	ISO 527
Flexural modulus, 23°C	**2100**	MPa	ISO 178
Flexural strength	**80**	MPa	ISO 178
Charpy notched impact strength, +23°C	**70**	kJ/m²	ISO 179/1eA
Izod notched impact strength, +23°C	**65**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 120**	-	ISO 2039-2
ASTM Data			
Tensile Modulus	**1900**	MPa	ASTM D 638
Tensile Strength at Yield	**52**	MPa	ASTM D 638
Tensile Strength at Break	**61**	MPa	ASTM D 638
Elongation at Break	**94**	%	ASTM D 638
Flexural Modulus	**2100**	MPa	ASTM D 790
Flexural Strength	**75**	MPa	ASTM D 790
Rockwell Hardness	**R 118**	-	ASTM D 785
Izod Impact notched, 1/8 in	**710**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**540**	J/m	ASTM D 256

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	**135**	°C	ISO 75-1/-2
Vicat softening temperature, B	**142**	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	**V-0**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Burning behav. at thickness h	**V-2**	class	IEC 60695-11-10
Thickness tested	**0.8**	mm	-
ASTM Data			
UL 94 Flame rating	**V-0**	-	UL 94
Thickness tested	**1.5**	mm	-
DTUL @ 264 psi	**129**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1180**	kg/m³	ISO 1183
Density	**1180**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**120**	°C	-
Pre-drying - Time	**2 - 6**	h	-
Processing humidity	**≤0.05**	%	-

Melt temperature	**290 - 310**	°C	-
Mold temperature	**40 - 100**	°C	-
Zone 1	**240 - 250**	°C	-
Zone 2	**260 - 270**	°C	-
Zone 3	**280 - 310**	°C	-
Nozzle temperature	**290 - 310**	°C	-
Screw speed	**50 - 150**	rpm	-
Injection pressure	**49 - 250**	MPa	-
Back pressure	**0.5 - 2**	MPa	-

Characteristics

Processing
Injection Molding

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific