INFINO LS-3104G

PC-GF10 — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**30**	g/10min	ISO 1133
Temperature	**250**	°C	-
Load	**10**	kg	-
ASTM Data			
Melt Flow Index, MFI	**30**	g/10min	ASTM D 1238
Temperature	**250**	°C	-
Load	**10**	kg	-
Mold Shrinkage, MD	**0.0035**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.0035**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	**80**	MPa	ISO 527
Flexural modulus, 23°C	**3800**	MPa	ISO 178
Flexural strength	**130**	MPa	ISO 178
Charpy notched impact strength, +23°C	**6**	kJ/m²	ISO 179/1eA
Rockwell hardness	**R 121**	-	ISO 2039-2
ASTM Data			
Tensile Modulus	**3300**	MPa	ASTM D 638
Tensile Strength at Yield	**78**	MPa	ASTM D 638
Tensile Strength at Break	**77**	MPa	ASTM D 638
Elongation at Break	**5**	%	ASTM D 638
Flexural Modulus	**3700**	MPa	ASTM D 790
Flexural Strength	**140**	MPa	ASTM D 790
Izod Impact notched, 1/8 in	**79**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**59**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 0.45 MPa	**135**	°C	ISO 75-1/-2
Vicat softening temperature, B	**143**	°C	ISO 306
Burning behav. at thickness h	**V-2**	class	IEC 60695-11-10
Thickness tested	**0.8**	mm	-
ASTM Data			
UL 94 Flame rating	**V-2**	-	UL 94
Thickness tested	**0.75**	mm	-
DTUL @ 264 psi	**135**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1250**	kg/m³	ISO 1183
Density	**1250**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**120**	°C	-
Pre-drying - Time	**4**	h	-
Processing humidity	**≤0.03**	%	-
Melt temperature	**290**	°C	-
Mold temperature	**100**	°C	-
Zone 1	**240 - 250**	°C	-
Zone 2	**260 - 270**	°C	-
Zone 3	**280 - 285**	°C	-
Nozzle temperature	**290**	°C	-
Screw speed	**30 - 70**	rpm	-
Injection pressure	**69 - 230**	MPa	-
Back pressure	**0.5 - 2**	MPa	-

Characteristics

Processing
Injection Molding

Applications
Electrical and Electronical

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific