INFINO TK-2046M

PCT-GF — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**18**	g/10min	ISO 1133
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Molding shrinkage, parallel	**0.7**	%	ISO 294-4, 2577
Molding shrinkage, normal	**0.7**	%	ISO 294-4, 2577
ASTM Data			
Melt Flow Index, MFI	**18**	g/10min	ASTM D 1238
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Mold Shrinkage, MD	**0.0065**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.0065**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**4200**	MPa	ISO 527
Yield stress	**60**	MPa	ISO 527
Stress at break	**60**	MPa	ISO 527
Strain at break	**1.6**	%	ISO 527
Flexural modulus, 23°C	**6900**	MPa	ISO 178
Flexural strength	**105**	MPa	ISO 178
Charpy notched impact strength, +23°C	**3.6**	kJ/m²	ISO 179/1eA
ASTM Data			
Tensile Modulus	**4800**	MPa	ASTM D 638
Tensile Strength at Yield	**73**	MPa	ASTM D 638
Tensile Strength at Break	**73**	MPa	ASTM D 638
Elongation at Break	**2.2**	%	ASTM D 638
Flexural Modulus	**6400**	MPa	ASTM D 790
Flexural Strength	**110**	MPa	ASTM D 790
Izod Impact unnotched, 1/8 in	**250**	J/m	ASTM D 256
Izod Impact unnotched, 1/4 in	**190**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**250**	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	**HB**	class	IEC 60695-11-10
Thickness tested	**1.5**	mm	-
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**3.0**	mm	-
ASTM Data			
UL 94 Flame rating	**HB**	-	UL 94
Thickness tested	**1.5**	mm	-
DTUL @ 264 psi	**250**	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	**1600**	kg/m³	ISO 1183
Density	**1600**	kg/m³	ASTM D 792

Processing Recommendation Extrusion	Value	Unit	Test Standard
Pre-drying - Temperature	**100**	°C	-
Pre-drying - Time	**4**	h	-
Processing humidity	**≤0.06**	%	-
Mold temperature	**50 - 60**	°C	-
Zone 1	**290 - 300**	°C	-
Zone 2	**300**	°C	-
Zone 3	**305 - 310**	°C	-
Nozzle temperature	**305 - 310**	°C	-

Characteristics

Processing
Other Extrusion

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific