INFINO SC-1220R

PC — Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	**22**	g/10min	ISO 1133
Temperature	**300**	°C	-
Load	**1.2**	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	**22**	g/10min	ASTM D 1238
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Mold Shrinkage, MD	**0.006**	mm/mm	ASTM D 955
Mold Shrinkage, TD	**0.006**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**2300**	MPa	ISO 527
Yield stress	**64**	MPa	ISO 527
Stress at break	**64**	MPa	ISO 527
Strain at break	**110**	%	ISO 527
Flexural modulus, 23°C	**2300**	MPa	ISO 178
Flexural strength	**92**	MPa	ISO 178
Charpy notched impact strength, +23°C	**60**	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	**2300**	MPa	ASTM D 638
Tensile Strength at Yield	**63**	MPa	ASTM D 638
Tensile Strength at Break	**63**	MPa	ASTM D 638
Elongation at Break	**110**	%	ASTM D 638
Flexural Modulus	**2300**	MPa	ASTM D 790
Flexural Strength	**90**	MPa	ASTM D 790
Rockwell Hardness	**R 120**	-	ASTM D 785
Izod Impact notched, 1/8 in	**740**	J/m	ASTM D 256
Izod Impact notched, 1/4 in	**98**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	**123**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**136**	°C	ISO 75-1/-2
Vicat softening temperature, B	**145**	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	**V-2**	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-2**	-	UL 94
Thickness tested	**0.75**	mm	-
DTUL @ 66 psi	**136**	°C	ASTM D 648
DTUL @ 264 psi	**125**	°C	ASTM D 648

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Dielectric Constant, 1 MHz	**2.9**	-	ASTM D 150

Optical properties	Value	Unit	Test Standard
ASTM Data			
Haze	**0.8**	%	ASTM D 1003

Light Transmittance	**89**	%	ASTM D 1003

Other properties	**Value**	**Unit**	**Test Standard**
Density	**1200**	kg/m³	ISO 1183
Density	**1200**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	**Value**	**Unit**	**Test Standard**
Pre-drying - Temperature	**100**	°C	-
Pre-drying - Time	**5 - 6**	h	-
Processing humidity	**≤0.05**	%	-
Melt temperature	**290**	°C	-
Mold temperature	**80 - 110**	°C	-
Zone 1	**250 - 280**	°C	-
Zone 2	**260 - 290**	°C	-
Zone 3	**270 - 300**	°C	-
Screw speed	**10 - 20**	rpm	-
Injection pressure	**69 - 130**	MPa	-
Back pressure	**5.9 - 8.8**	MPa	-

Characteristics

Processing
Injection Molding

Applications
Electrical and Electronical

Delivery form
Pellets, Natural Color

Regional Availability
North America, Europe, Asia Pacific