

INFINO GC-1033

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	35	g/10min	ISO 1133
Temperature	220	°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	35	g/10min	ASTM D 1238
Temperature	220	°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	2300	MPa	ISO 527
Yield stress	59	MPa	ISO 527
Stress at break	60	MPa	ISO 527
Strain at break	30	%	ISO 527
Flexural modulus, 23°C	2400	MPa	ISO 178
Flexural strength	85	MPa	ISO 178
Charpy notched impact strength, +23°C	30	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	50	kJ/m ²	ISO 180/1A
Rockwell hardness	R 119	-	ISO 2039-2
ASTM Data			
Tensile Modulus	2300	MPa	ASTM D 638
Tensile Strength at Yield	58	MPa	ASTM D 638
Tensile Strength at Break	59	MPa	ASTM D 638
Elongation at Break	30	%	ASTM D 638
Flexural Modulus	2300	MPa	ASTM D 790
Flexural Strength	87	MPa	ASTM D 790
Rockwell Hardness	R 119	-	ASTM D 785
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256
Izod Impact notched, 1/4 in	150	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	86	°C	ISO 75-1/-2
Vicat softening temperature, B	107	°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-0	class	IEC 60695-11-10
Thickness tested	3.0	mm	-
ASTM Data			
UL 94 Flame rating	V-0	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 264 psi	94	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1190	kg/m ³	ISO 1183
Density	1190	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.04	%	-
Melt temperature	250 - 270	°C	-

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Mold temperature	60 - 90	°C	-
Zone 1	230 - 250	°C	-
Zone 2	240 - 260	°C	-
Zone 3	250 - 270	°C	-
Nozzle temperature	260	°C	-
Screw speed	20 - 200	rpm	-
Injection pressure	98	MPa	-
Back pressure	0.5 - 2.9	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color