

INFINO LI-1000

(PC+ABS)

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	0.0056	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.0058	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	2000	MPa	ISO 527
Yield stress	55	MPa	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	78	%	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Charpy notched impact strength, +23°C	39	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	36	kJ/m ²	ISO 180/1A
Rockwell hardness	R 117	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1800	MPa	ASTM D 638
Tensile Strength at Yield	56	MPa	ASTM D 638
Tensile Strength at Break	64	MPa	ASTM D 638
Elongation at Break	119	%	ASTM D 638
Flexural Modulus	2000	MPa	ASTM D 790
Flexural Strength	74	MPa	ASTM D 790
Rockwell Hardness	R 117	-	ASTM D 785
Izod Impact notched, 1/8 in	640	J/m	ASTM D 256
Izod Impact notched, 1/4 in	550	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 1.80 MPa	122	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	138	°C	ISO 75-1/-2
Vicat softening temperature, B	143	°C	ISO 306
ASTM Data			
DTUL @ 66 psi	142	°C	ASTM D 648
DTUL @ 264 psi	132	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1200	kg/m ³	ISO 1183
Density	1200	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.05	%	-
Melt temperature	260	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	220 - 230	°C	-
Zone 2	240 - 250	°C	-
Zone 3	260 - 270	°C	-
Nozzle temperature	270	°C	-
Screw speed	50 - 150	rpm	-

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Injection pressure	93	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Delivery form

Pellets, Natural Color