

INFINO WP-1053

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	45	g/10min	ISO 1133
Temperature	250	°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	45	g/10min	ASTM D 1238
Temperature	250	°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			
ISO Data			
Tensile Modulus	2200	MPa	ISO 527
Yield stress	54	MPa	ISO 527
Stress at break	46	MPa	ISO 527
Strain at break	78	%	ISO 527
Flexural modulus, 23°C	2250	MPa	ISO 178
Flexural strength	75	MPa	ISO 178
Charpy notched impact strength, +23°C	45	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	45	kJ/m ²	ISO 180/1A
Rockwell hardness	R 112	-	ISO 2039-2
ASTM Data			
Tensile Strength at Yield	53	MPa	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	74	MPa	ASTM D 790
Rockwell Hardness	R 112	-	ASTM D 785
Izod Impact notched, 1/8 in	470	J/m	ASTM D 256
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	94	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	115	°C	ISO 75-1/-2
Vicat softening temperature, B	114	°C	ISO 306
ASTM Data			
DTUL @ 264 psi	105	°C	ASTM D 648
Other properties			
Value			
Density	1120	kg/m ³	ISO 1183
Density	1120	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Value			
Pre-drying - Temperature	80	°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	-
Injection pressure	69	MPa	-
Back pressure	0.5 - 2	MPa	-

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Characteristics**Processing**

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific