

INFINO WP-1071

(PC+ABS)

Lotte Chemical Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	24	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	24	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	1700	MPa	ISO 527
Yield stress	46	MPa	ISO 527
Stress at break	50	MPa	ISO 527
Strain at break	91	%	ISO 527
Flexural modulus, 23°C	1800	MPa	ISO 178
Flexural strength	68	MPa	ISO 178
Charpy notched impact strength, +23°C	39	kJ/m ²	ISO 179/1eA
Izod notched impact strength, +23°C	34	kJ/m ²	ISO 180/1A
Rockwell hardness	R 107	-	ISO 2039-2
ASTM Data			
Tensile Modulus	1800	MPa	ASTM D 638
Tensile Strength at Yield	47	MPa	ASTM D 638
Tensile Strength at Break	48	MPa	ASTM D 638
Elongation at Break	102	%	ASTM D 638
Flexural Modulus	1700	MPa	ASTM D 790
Flexural Strength	64	MPa	ASTM D 790
Rockwell Hardness	R 107	-	ASTM D 785
Izod Impact notched, 1/8 in	590	J/m	ASTM D 256
Izod Impact notched, 1/4 in	500	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	530	J/m	ASTM D 256
Temperature	-30	°C	-
Thermal properties			
ISO Data			
Temp. of deflection under load, 1.80 MPa	109	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	127	°C	ISO 75-1/-2
Vicat softening temperature, B	133	°C	ISO 306
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 @ 66 psi	132	°C	ASTM D 648
DTUL @ 264 psi	116	°C	ASTM D 648
Other properties			
Density	1140	kg/m ³	ISO 1183
Density	1140	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	90 - 100	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.02	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 90	°C	-
Zone 1	210 - 230	°C	-
Zone 2	230 - 250	°C	-
Zone 3	250 - 265	°C	-
Nozzle temperature	250 - 280	°C	-
Screw speed	50 - 150	rpm	-
Injection pressure	78	MPa	-
Back pressure	0.5 - 2	MPa	-

Characteristics

Processing

Injection Molding

Applications

Automotive

Delivery form

Pellets, Natural Color

Regional Availability

North America, Europe, Asia Pacific

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat