

<b>Infino WP-1089</b>			
<b>(PC+ABS)</b>		Lotte Chemical Corporation	
<b>Processing/Physical Characteristics</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ASTM Data</b>			
Melt Flow Index	47	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
Density	1130	kg/m <sup>3</sup>	ASTM D 792
<b>Rheological properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
<b>ISO Data</b>			
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6	%	ISO 294-4, 2577
Melt flow index, MFI	47	g/10min	ISO 1133
MFI temperature	250	°C	-
MFI load	10	kg	-
<b>Mechanical properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
<b>ISO Data</b>			
Tensile Modulus	2100	MPa	ISO 527
Yield stress	52	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	60	%	ISO 527
Charpy notched impact strength, +23°C	51	kJ/m <sup>2</sup>	ISO 179/1eA
Flexural modulus, 23°C	2200	MPa	ISO 178
Flexural strength	80	MPa	ISO 178
Izod Impact notched, 23°C	46	kJ/m <sup>2</sup>	ISO 180/1A
Izod Impact notched	32	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-
Rockwell hardness	R 113	-	ISO 2039-2
<b>ASTM Data</b>			
Tensile Modulus	2100	MPa	ASTM D 638
Tensile Strength at Yield	53	MPa	ASTM D 638
Tensile Strength at Break	44	MPa	ASTM D 638
Elongation at Break	80	%	ASTM D 638
Flexural Modulus	2100	MPa	ASTM D 790
Flexural Strength	76	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	590	J/m	ASTM D 256
Izod Impact notched, 1/4 in	420	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	390	J/m	ASTM D 256
Temperature	-30	°C	-
<b>Thermal properties</b>			
<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>	
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	107 <sup>[ann.]</sup>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	126 <sup>[ann.]</sup>	°C	ISO 75-1/-2
Vicat softening temperature, 50°C/h 50N	126	°C	ISO 306
Coeff. of linear therm. expansion, parallel	81	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	83	E-6/K	ISO 11359-1/-2
<b>ASTM Data</b>			

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Coefficient of Thermal Expansion, MD	81	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	83	E-6/K	ASTM D 696
DTUL @ 66 psi	130	°C	ASTM D 648
DTUL @ 264 psi	110	°C	ASTM D 648
ann.: Assessed (Min)			
<b>Other properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Density	1130	kg/m <sup>3</sup>	ISO 1183
<b>Processing Recommendation Injection Molding</b>			
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 - 80	rpm	-
Injection pressure	59 - 59	MPa	-
Back pressure	0.5 - 2.5	MPa	-
<b>Characteristics</b>			
<b>Processing</b>		<b>Applications</b>	
Injection Molding		Automotive	
<b>Delivery form</b>			
Pellets, Natural Color			