

# Infino CF-1070

Lotte Chemical Corporation - Polycarbonate

Tuesday, June 27, 2023

## General Information

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	

## ASTM & ISO Properties <sup>1</sup>

### Physical

	Nominal Value	Unit	Test Method
Density / Specific Gravity (Natural)	1.20	g/cm <sup>3</sup>	ASTM D792
Density (Natural)	1.20	g/cm <sup>3</sup>	ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238
250°C/10.0 kg	13	g/10 min	
300°C/1.2 kg	8.0	g/10 min	
Melt Mass-Flow Rate (MFR)			ISO 1133
250°C/10.0 kg	13	g/10 min	
300°C/1.2 kg	8.0	g/10 min	
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.40 to 0.70	%	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.40 to 0.70	%	
Flow : 2.00 mm	0.40 to 0.70	%	

### Mechanical

	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	1960	MPa	ASTM D638
Tensile Modulus	2000	MPa	ISO 527-1/50
Tensile Strength <sup>2</sup> (Yield)	58.8	MPa	ASTM D638
Tensile Stress (Yield)	58.0	MPa	ISO 527-2/50
Tensile Strength <sup>2</sup> (Break)	58.8	MPa	ASTM D638
Tensile Stress (Break)	60.0	MPa	ISO 527-2/50
Tensile Elongation <sup>2</sup> (Break)	100	%	ASTM D638
Tensile Strain (Break)	100	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	1960	MPa	ASTM D790
Flexural Modulus <sup>4</sup>	2100	MPa	ISO 178
Flexural Strength <sup>3</sup>	83.4	MPa	ASTM D790
Flexural Stress <sup>4</sup>	80.0	MPa	ISO 178

### Impact

	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (23°C)	70	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
23°C, 3.18 mm	690	J/m	
23°C, 6.35 mm	540	J/m	
Notched Izod Impact Strength <sup>5</sup> (23°C)	65	kJ/m <sup>2</sup>	ISO 180/1A

### Thermal

	Nominal Value	Unit	Test Method
Vicat Softening Temperature	140	°C	ISO 306/B50

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## Lotte Chemical Corporation - Polycarbonate

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.8 mm		V-2	
2.5 mm		V-2	
3.0 mm		V-2	

Processing Information			
Injection	Nominal Value	Unit	
Drying Temperature			
Desiccant Dryer	100	°C	
Hot Air Dryer	100	°C	
Drying Time			
Desiccant Dryer	2.0 to 4.0	hr	
Hot Air Dryer	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	275 to 285	°C	
Middle Temperature	285 to 295	°C	
Front Temperature	295 to 305	°C	
Nozzle Temperature	300	°C	
Mold Temperature	70 to 100	°C	
Injection Pressure	98.1	MPa	
Back Pressure	0.981 to 2.94	MPa	
Screw Speed	40 to 80	rpm	

Injection Notes
Hot Runner Temperature: 300°C

### Notes

<sup>1</sup> Typical properties: these are not to be construed as specifications.

<sup>2</sup> 50 mm/min

<sup>3</sup> 2.8 mm/min

<sup>4</sup> 2.0 mm/min

<sup>5</sup> 4mm