

# Infino AE-3063I

LOTTE ADVANCED MATERIALS CO., LTD. - Polycarbonate + PBT

Saturday, January 18, 2020

## General Information

### General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North 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) (250°C/10.0 kg)	45	g/10 min	ASTM D1238
Melt Mass-Flow Rate (MFR) (250°C/10.0 kg)	45	g/10 min	ISO 1133
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	ASTM D955
Molding Shrinkage - Across Flow (3.20 mm)	0.50 to 0.80	%	ASTM D955
Molding Shrinkage			ISO 294-4
Across Flow : 2.00 mm	0.50 to 0.80	%	
Flow : 2.00 mm	0.50 to 0.80	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus <sup>2</sup>	1700	MPa	ASTM D638
Tensile Modulus	1600	MPa	ISO 527-2/50
Tensile Strength <sup>2</sup> (Yield)	49.0	MPa	ASTM D638
Tensile Stress (Yield)	50.0	MPa	ISO 527-2/50
Tensile Strength <sup>2</sup> (Break)	47.0	MPa	ASTM D638
Tensile Stress (Break)	48.0	MPa	ISO 527-2/50
Tensile Elongation <sup>2</sup> (Break)	120	%	ASTM D638
Tensile Strain (Break)	120	%	ISO 527-2/50
Flexural Modulus <sup>3</sup>	1900	MPa	ASTM D790
Flexural Modulus <sup>4</sup>	1800	MPa	ISO 178
Flexural Strength <sup>3</sup>	69.0	MPa	ASTM D790
Flexural Stress <sup>4</sup>	67.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength <sup>5</sup> (23°C)	54	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Izod Impact			ASTM D256
-30°C, 6.35 mm	370	J/m	
23°C, 3.18 mm	760	J/m	
23°C, 6.35 mm	640	J/m	
Notched Izod Impact Strength <sup>5</sup> (23°C)	52	kJ/m <sup>2</sup>	ISO 180/1A
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	92.0	°C	

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## LOTTE ADVANCED MATERIALS CO., LTD. - Polycarbonate + PBT

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature 1.8 MPa, Unannealed, 4.00 mm	78.0	°C	ISO 75-2/A
Vicat Softening Temperature	120	°C	ISO 306/B50

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature		
Desiccant Dryer	100	°C
Hot Air Dryer	110	°C
Drying Time		
Desiccant Dryer	4.0	hr
Hot Air Dryer	4.0	hr
Suggested Max Moisture	< 0.050	%
Rear Temperature	230 to 240	°C
Middle Temperature	240 to 250	°C
Front Temperature	250 to 260	°C
Nozzle Temperature	260	°C
Mold Temperature	40 to 60	°C
Injection Pressure	49.0 to 245	MPa
Back Pressure	0.490 to 1.96	MPa
Screw Speed	50 to 150	rpm

### Injection Notes

Hot Runner Temperature: 260°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