

Infino WP-1089

Polycarbonate + ABS

SAMSUNG SDI CO., LTD.

Message:

Infino WP-1089 is a Polycarbonate + ABS (PC+ABS) product. It is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

General Information			
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR)			ASTM D1238, ISO 1133
250°C/10.0 kg	47	g/10 min	
260°C/5.0 kg	27	g/10 min	
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.50 to 0.60	%	
Across Flow : 3.20 mm	0.50 to 0.60	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
R-Scale	108		ASTM D785
R-Scale	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2100	MPa	ASTM D638
--	2100	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	53.0	MPa	ASTM D638
Yield	52.0	MPa	ISO 527-2/50
Break ³	44.0	MPa	ASTM D638
Break	45.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	80	%	ASTM D638
Break	60	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2100	MPa	ASTM D790
-- ⁶	2200	MPa	ISO 178
Flexural Strength			
-- ⁷	76.0	MPa	ASTM D790
-- ⁸	80.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	51	kJ/m ²	ISO 179/1eA
Notched Izod Impact			

-30°C, 3.18 mm	390	J/m	ASTM D256
-30°C, 6.35 mm	200	J/m	ASTM D256
23°C, 3.18 mm	590	J/m	ASTM D256
23°C, 6.35 mm	420	J/m	ASTM D256
-30°C ¹⁰	32	kJ/m ²	ISO 180/1A
23°C ¹¹	46	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	130	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	123	°C	ISO 75-2/B
0.45 MPa, Annealed	125	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	110	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	104	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	105	°C	ISO 75-2/A
Vicat Softening Temperature	126	°C	ISO 306/B50
CLTE			ASTM D696, ISO 11359-2
Flow : 40 to 100°C	8.1E-5	cm/cm/°C	
Transverse : 40 to 100°C	8.3E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature			
--	90.0	°C	
Desiccant Dryer	80.0	°C	
Drying Time			
--	4.0	hr	
Desiccant Dryer	4.0	hr	
Suggested Max Moisture	< 0.030	%	
Rear Temperature	220 to 240	°C	
Middle Temperature	230 to 250	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	260	°C	
Mold Temperature	50.0 to 70.0	°C	
Injection Pressure	58.8	MPa	
Back Pressure	0.490 to 2.45	MPa	
Screw Speed	50 to 80	rpm	
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	50 mm/min		
4.	50 mm/min		
5.	2.8 mm/min		
6.	2.0 mm/min		
7.	2.8 mm/min		

8.	2.0 mm/min
9.	Thickness: 4 mm
10.	Thickness 4 mm
11.	Thickness: 4 mm

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