

Infino SA-1220

Polycarbonate

LOTTE ADVANCED MATERIALS CO., LTD.

Message:

Infino SA-1220 is a polycarbonate (PC) product. It is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. Typical application areas are: electrical/electronic applications. The main characteristics are: flame retardant/rated flame.

General Information			
UL YellowCard	E115797-100729045		
Features	General		
Uses	Switch		
Physical	Nominal Value	Unit	Test Method
Specific Gravity (Natural)	1.20	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	20	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			
Flow: 3.20mm	0.50 - 0.70	%	ASTM D955
Transverse flow: 3.20mm	0.50 - 0.70	%	ASTM D955
Lateral flow: 3.20mm	0.50 - 0.70	%	ISO 2577
Traffic: 3.20mm	0.50 - 0.70	%	ISO 2577
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			
Class r	120		ASTM D785
R scale	120		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2100	MPa	ASTM D638
--	2000	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	64.0	MPa	ASTM D638
Yield	60.0	MPa	ISO 527-2/50
Fracture ³	64.0	MPa	ASTM D638
Fracture	65.0	MPa	ISO 527-2/50
Tensile Elongation			
Fracture ⁴	65	%	ASTM D638
Fracture	65	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2300	MPa	ASTM D790
-- ⁶	2050	MPa	ISO 178
Flexural Strength			
-- ⁷	97.0	MPa	ASTM D790

-- ⁸	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	25	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
23°C, 3.18 mm	690	J/m	ASTM D256
23°C, 6.35 mm	120	J/m	ASTM D256
23°C ¹⁰	45	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 6.40mm	130	°C	ASTM D648
0.45 MPa, unannealed, 4.00mm	130	°C	ISO 75-2/B
1.8 MPa, unannealed, 6.40mm	120	°C	ASTM D648
1.8 MPa, not annealed, 4.00mm	120	°C	ISO 75-2/A
Vicat Softening Temperature	138	°C	ISO 306/B50
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.5 mm	V-2		UL 94
3.0 mm	V-2		UL 94
Injection	Nominal Value	Unit	
Drying Temperature			
--	110	°C	
Hot air dryer	110	°C	
Drying Time			
--	4.0	hr	
Hot air dryer	4.0	hr	
Suggested Max Moisture	0.020 - 0.030	%	
Rear Temperature	240 - 250	°C	
Middle Temperature	260 - 270	°C	
Front Temperature	280 - 285	°C	
Nozzle Temperature	290	°C	
Mold Temperature	50 - 80	°C	
Injection Pressure	68.6 - 206	MPa	
Back Pressure	0.490	MPa	
Screw Speed	30	rpm	
Injection instructions			
Hot Runner Manifold Temperature: 280°C Hot Runner Valve Nozzle Temperature: 280°C			
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: 4mm
10.	Thickness: 4mm

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