

Infino WP-1098

Polycarbonate + ABS

SAMSUNG SDI CO., LTD.

Message:

Infino WP-1098 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) (250°C/10.0 kg)	30	g/10 min	ASTM D1238, ISO 1133
Molding Shrinkage			ASTM D955, ISO 2577
Flow : 3.20 mm	0.50	%	
Across Flow : 3.20 mm	0.70	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	111		ASTM D785, ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1700	MPa	ASTM D638
--	1700	MPa	ISO 527-2/50
Tensile Strength			
Yield ²	49.0	MPa	ASTM D638
Yield	50.0	MPa	ISO 527-2/50
Break ³	49.0	MPa	ASTM D638
Break	49.0	MPa	ISO 527-2/50
Tensile Elongation			
Break ⁴	100	%	ASTM D638
Break	100	%	ISO 527-2/50
Flexural Modulus			
-- ⁵	2000	MPa	ASTM D790
-- ⁶	1950	MPa	ISO 178
Flexural Strength			
-- ⁷	71.0	MPa	ASTM D790
-- ⁸	70.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength ⁹ (23°C)	50	kJ/m ²	ISO 179/1eA
Notched Izod Impact			
-30°C, 3.18 mm	160	J/m	ASTM D256
-30°C, 6.35 mm	150	J/m	ASTM D256
23°C, 3.18 mm	610	J/m	ASTM D256

23°C, 6.35 mm	340	J/m	ASTM D256
-30°C ¹⁰	15	kJ/m ²	ISO 180/1A
23°C ¹¹	52	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 6.40 mm	115	°C	ASTM D648
0.45 MPa, Unannealed, 4.00 mm	106	°C	ISO 75-2/B
0.45 MPa, Annealed	122	°C	ISO 75-2/B
1.8 MPa, Unannealed, 6.40 mm	106	°C	ASTM D648
1.8 MPa, Unannealed, 4.00 mm	97.0	°C	ISO 75-2/A
1.8 MPa, Annealed, 4.00 mm	111	°C	ISO 75-2/A
Vicat Softening Temperature	120	°C	ISO 306/B50
Optical	Nominal Value		Test Method
Gloss ¹² (60°)	35		ASTM D2457
Gloss ¹³ (60°)	35		ISO 2813
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
12.	23°C, 50% RH
13.	23°C, 50% RH

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

