

Lucon® CP6050

Polycarbonate + ABS

LG Chem Ltd.

Message:

Description

Electrostatic Dissipation

(1.0E+04 ~ 1.0E+06 ohm)

Low Liquid Particle Counts

Application

HDD parts

General Information			
Filler / Reinforcement	Carbon nano filler		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.17 - 1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	58.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	93.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	125	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4 - 1.0E+8	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+4 - 1.0E+8	ohms · cm	ASTM D257
Additional Information	Nominal Value	Unit	
Electrostatic Decay ⁵		sec	
Injection	Nominal Value	Unit	
Drying Temperature	80 - 100	°C	
Drying Time	3.0 - 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	240 - 270	°C	
Middle Temperature	245 - 275	°C	
Front Temperature	250 - 280	°C	
Nozzle Temperature	250 - 280	°C	

Processing (Melt) Temp	250 - 280	°C
Mold Temperature	50 - 80	°C
Back Pressure	0.981 - 3.92	MPa
Screw Speed	40 - 70	rpm

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	
5.	1000V to <100V	

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