

Lupoy® SC5004T

Polycarbonate + Polyester

LG Chem Ltd.

Message:

Description

General Purpose, Transparency, High Flow

Application

Keypad for Mobile Phone

General Information			
Features	General Purpose		
	High Flow		
Uses	Cell Phones		
	Electrical/Electronic Applications		
Appearance	Clear/Transparent		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	60.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 150	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2260	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	97.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	123	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	95.0 to 105	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	260 to 270	°C	
Middle Temperature	265 to 280	°C	
Front Temperature	265 to 280	°C	

Nozzle Temperature	265 to 295	°C
Processing (Melt) Temp	265 to 290	°C
Mold Temperature	40.0 to 70.0	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm

NOTE

1.	50 mm/min
2.	50 mm/min
3.	10 mm/min
4.	10 mm/min
5.	18.6kg

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