

Lumiplas® LD7650

Polycarbonate

LG Chem Ltd.

Message:

Description

Light diffusion

Application

(LED) Lamp Cover, Signboard, Lighting decoration of electronic device

General Information			
Features	Good Light Diffusion		
Uses	Lighting Applications		
	Electrical/Electronic Applications		
	Illumination diffuser		
	Lighting device		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	61.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2260	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	93.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	780	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	130	°C	ASTM D648
CLTE - Flow	6.8E-5	cm/cm/°C	ASTM D696
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI	80.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94

0.800 mm	V-2	UL 94	
1.60 mm	V-2	UL 94	
Additional Information	Nominal Value	Unit	Test Method
Transparency (1.00 mm)	65	%	JIS K7361
Minimum Moisture Content	0.020	%	
Injection	Nominal Value	Unit	
Drying Temperature	100 - 200	°C	
Drying Time	3.0 - 4.0	hr	
Rear Temperature	260 - 280	°C	
Middle Temperature	280 - 300	°C	
Front Temperature	290 - 310	°C	
Nozzle Temperature	290 - 310	°C	
Processing (Melt) Temp	300 - 320	°C	
Mold Temperature	80.0 - 120	°C	
Back Pressure	0.981 - 3.92	MPa	
Screw Speed	40 - 70	rpm	
Extrusion	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	3.0 - 4.0	hr	
Cylinder Zone 1 Temp.	260 - 280	°C	
Cylinder Zone 2 Temp.	270 - 300	°C	
Cylinder Zone 3 Temp.	270 - 300	°C	
Cylinder Zone 4 Temp.	270 - 300	°C	
Adapter Temperature	280 - 300	°C	
Melt Temperature	300 - 320	°C	
Die Temperature	260 - 295	°C	
Extrusion instructions			
Minimum Moisture Content: 0.02%Roll Stack Temperature - Top: 120-150°CRoll Stack Temperature - Middle: 120-150°CRoll Stack Temperature - Bottom: 120-150°C			
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	15 mm/min		
4.	15 mm/min		

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