

Lucon® CP6134F

Polycarbonate

LG Chem Ltd.

Message:

Description

Antistatic

Halogen Free Flame Retardant

Application

Copy Machine & Tray Paper guide

General Information			
Filler / Reinforcement	Mineral filler		
	Carbon nano filler		
Additive	Antistatic property		
Features	Antistatic property		
	Halogen-free		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30 - 1.40	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.10 - 0.30	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	66.7	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	6860	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	94.0	°C	ASTM D648
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI	80.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13 - 1.0E+15	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+14 - 1.0E+17	ohms · cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method

Flame Rating		UL 94
1.5 mm	V-0	UL 94
3.0 mm	V-0	UL 94
Injection	Nominal Value	Unit
Drying Temperature	75 - 85	°C
Drying Time	3.0 - 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	230 - 250	°C
Middle Temperature	245 - 265	°C
Front Temperature	260 - 275	°C
Nozzle Temperature	260 - 275	°C
Processing (Melt) Temp	245 - 275	°C
Mold Temperature	60 - 90	°C
Back Pressure	0.981 - 3.92	MPa
Screw Speed	40 - 70	rpm
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	

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