

Lumiplas® LD7650I

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	Electrical/Electronic Applications		
	Lighting Applications		
	Lighting Diffusers		
	Lighting Fixtures		
Processing Method	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)	33	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	ASTM D955
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)	150	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	124	°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 Str	80.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating		UL 94	
0.800 mm	V-2		
1.60 mm	V-2		
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 to 200	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	260 to 280	°C
Middle Temperature	270 to 290	°C
Front Temperature	280 to 300	°C
Nozzle Temperature	280 to 300	°C
Processing (Melt) Temp	290 to 310	°C
Mold Temperature	70.0 to 100	°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.	15 mm/min	
4.	15 mm/min	

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