

Lumiplas LD590T

Methyl Methacrylate / ABS

LG Chem Ltd.

Message:

Description
Light diffusion, High Impact
Application
(LED) Lamp cover, Signboard, Lighting Decoration of Electronic Device

General Information			
Features	Impact resistance, high		
Uses	Electrical components		
	Soft handle		
Processing Method	Extrusion		
	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.12	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	8.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 - 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	108		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	49.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	30	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	78.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	110	J/m	ASTM D256
23°C, 6.40 mm	98	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	81.0	°C	ASTM D648
CLTE - Flow	8.4E-5	cm/cm/°C	ASTM D696
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating	HB		UL 94

Injection	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	< 0.010	%
Rear Temperature	190 - 210	°C
Middle Temperature	200 - 220	°C
Front Temperature	220 - 250	°C
Nozzle Temperature	230 - 250	°C
Processing (Melt) Temp	230 - 250	°C
Mold Temperature	40.0 - 60.0	°C
Back Pressure	0.981 - 3.92	MPa
Screw Speed	30 - 60	rpm

Extrusion	Nominal Value	Unit
Drying Temperature	70.0 - 80.0	°C
Drying Time	3.0 - 4.0	hr
Suggested Max Moisture	< 0.010	%
Cylinder Zone 1 Temp.	190 - 210	°C
Cylinder Zone 2 Temp.	200 - 230	°C
Cylinder Zone 3 Temp.	210 - 240	°C
Cylinder Zone 4 Temp.	220 - 250	°C
Adapter Temperature	220 - 250	°C
Melt Temperature	230 - 250	°C
Die Temperature	220 - 250	°C

Extrusion instructions

RollStack Temperature: 60 to 100°C RollStack Temperature: 70 to 90°C RollStack Temperature: 60 to 80°C

NOTE

1. 50 mm/min
2. 50 mm/min
3. 15 mm/min
4. 15 mm/min
5. 18.6kg

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