

Lupoy® SC3154

Polycarbonate

LG Chem Ltd.

Message:

Description

General Purpose, Good Toughness, Dimensional Stability, Good Surface, Chemical Resistance

Application

Moible Phone Housing and Components

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Features	General Purpose		
	Good Chemical Resistance		
	Good Dimensional Stability		
	Good Surface Finish		
	Good Toughness		
Uses	Cell Phones		
	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	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)	0.40 to 0.50	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	123		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	47.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	25	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	3040	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	220	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	137	°C	ASTM D648
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 (1.70 mm)	HB	UL 94
Injection	Nominal Value	Unit
Drying Temperature	100 to 120	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	280 to 295	°C
Middle Temperature	285 to 300	°C
Front Temperature	290 to 305	°C
Nozzle Temperature	290 to 305	°C
Processing (Melt) Temp	295 to 315	°C
Mold Temperature	90.0 to 110	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm
NOTE		
1.	5.0 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	
5.	18.6kg	

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