

Lucon® CP6054

Polycarbonate

LG Chem Ltd.

Message:

Description

Electrostatic Dissipation

(1.0E+04 ~ 1.0E+06 ohm)

Application

LCD Cell Tray

General Information			
Filler / Reinforcement		Glass fiber reinforced material Carbon nano filler	
Uses		Mobile phone	
Processing Method		Injection molding	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/5.0 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.30 - 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	108	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	8.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	5000	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	137	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	78	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	135	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4 - 1.0E+6	ohms	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	100 - 120	°C	
Drying Time	3.0 - 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	270 - 300	°C	
Middle Temperature	290 - 310	°C	
Front Temperature	300 - 330	°C	
Nozzle Temperature	300 - 330	°C	
Processing (Melt) Temp	300 - 330	°C	
Mold Temperature	90 - 120	°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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