

General Information
Product Description

Description

General Purpose, High Flow, High Impact, Chemical Resistance

Application

Mobile Phone Housing

General

Material Status	• Commercial: Active
Availability	<ul style="list-style-type: none"> • Asia Pacific • Europe • Latin America • North America
Features	<ul style="list-style-type: none"> • Chemical Resistant • General Purpose • High Flow • High Impact Resistance
Uses	<ul style="list-style-type: none"> • Cell Phones • Electrical/Electronic Applications
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	18	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C, 3.20 mm, Injection Molded)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ²			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	54.9	MPa	
Tensile Elongation ²			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	100	%	
Flexural Modulus ³ (23°C, 3.20 mm, Injection Molded)	2060	MPa	ASTM D790
Flexural Strength ³ (23°C, 3.20 mm, Injection Molded)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm, Injection Molded	390	J/m	
23°C, 3.20 mm, Injection Molded	640	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C, Injection Molded)	117		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	128	°C	
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.70 mm)	HB		UL 94

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Lupoy® SC1004L

LG Chem Ltd. - Polycarbonate

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	100 to 110	°C
Drying Time	3.0 to 5.0	hr
Minimum Moisture Content	0.020	%
Rear Temperature	275 to 290	°C
Middle Temperature	285 to 305	°C
Front Temperature	290 to 310	°C
Nozzle Temperature	285 to 305	°C
Processing (Melt) Temp	290 to 310	°C
Mold Temperature	80 to 110	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 50 mm/min

³ 10 mm/min