

General Information
Product Description

Description

General Purpose, Transparency, High Flow

Application

Keypad for Mobile Phone

General

Material Status	• Commercial: Active	
Availability	• Asia Pacific • Europe	• Latin America • North America
Features	• General Purpose	• High Flow
Uses	• Cell Phones	• Electrical/Electronic Applications
Appearance	• Clear/Transparent	
Processing Method	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield, 3.20 mm)	60.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 150	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2260	MPa	ASTM D790
Flexural Strength ³ (Yield, 3.20 mm)	97.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	690	J/m	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁴ 0.45 MPa, Unannealed, 6.40 mm	123	°C	ASTM D648

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	95 to 105	°C
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	260 to 270	°C
Middle Temperature	265 to 280	°C
Front Temperature	265 to 280	°C
Nozzle Temperature	265 to 295	°C
Processing (Melt) Temp	265 to 290	°C

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Lupoy® SC5004T

LG Chem Ltd. - Polycarbonate + Polyester

Injection	Nominal Value	Unit
Mold Temperature	40 to 70	°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

⁴ 18.6kg