

SolutionPartner


LUMIPLAS LD8650I

Injection molding grade

Description

Light diffusion
Weatherability

Application

(LED) Lamp cover, Signboard
Lighting decoration of electronic device

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.20
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5~0.8
Melt Flow Rate	300 °C/1.2kg	ASTM D1238	g/10min	33
Outdoor Suitability		UL746C		f1
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	630
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	>100
Flexural Strength, 6.4mm	15mm/min	ASTM D790	kg/cm ²	950
Flexural Modulus, 6.4mm	15mm/min	ASTM D790	kg/cm ²	23,000
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	15
	-30 °C		kg·cm/cm	
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	126
	4.6kg		°C	
Flammability		UL94		
0.5mm			class	V-2
1.6mm			class	V-2
2.5mm			class	V-2
3.0mm			class	V-2
Relative Temperature Index		UL 746B		
Electrical			°C	120
Mechanical with Impact			°C	105
Mechanical without Impact			°C	120
Optical				
Transparency (@1mm)		JIS K7361	%	65

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 10-Dec-15

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	100 ~ 120
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		°C	280 ~ 300
Cylinder Temperature	Rear	°C	250 ~ 270
	Middle	°C	260 ~ 280
	Front	°C	270 ~ 290
Nozzle Temperature		°C	270 ~ 290
Mold Temperature		°C	60 ~100
Back Pressure		kg/cm ²	10 ~ 40
Screw Speed		rpm	40 ~ 70

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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