# LUPOY SC1004ML

PC LG Chem

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|---|---|---|---|
| **ASTM Data** | | | |
| Melt Flow Index, MFI | **12** | g/10min | ASTM D 1238 |
| Temperature | **300** | °C | - |
| Load | **1.2** | kg | - |
| Mold Shrinkage, MD | **0.0065** | mm/mm | ASTM D 955 |

| Mechanical properties | Value | Unit | Test Standard |
|---|---|---|---|
| **ASTM Data** | | | |
| Tensile Strength at Yield | **56.9** | MPa | ASTM D 638 |
| Elongation at Break | **130** | % | ASTM D 638 |
| Flexural Modulus | **2158** | MPa | ASTM D 790 |
| Flexural Strength | **88.3** | MPa | ASTM D 790 |
| Rockwell Hardness | **R 117** | - | ASTM D 785 |
| Izod Impact notched, 1/8 in | **660** | J/m | ASTM D 256 |
| Izod Impact notched, Low-Temperature | **283** | J/m | ASTM D 256 |
| Temperature | **-30** | °C | - |

| Thermal properties | Value | Unit | Test Standard |
|---|---|---|---|
| **ASTM Data** | | | |
| UL 94 Flame rating | **HB** | - | UL 94 |
| Thickness tested | **0.7** | mm | - |
| DTUL @ 264 psi | **130** | °C | ASTM D 648 |

| Other properties | Value | Unit | Test Standard |
|---|---|---|---|
| Density | **1200** | kg/m³ | ASTM D 792 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|---|---|---|
| Pre-drying - Temperature | **100 - 110** | °C | - |
| Pre-drying - Time | **3 - 5** | h | - |
| Processing humidity | **≤0.02** | % | - |
| Melt temperature | **290 - 310** | °C | - |
| Mold temperature | **80 - 110** | °C | - |
| Zone 1 | **275 - 290** | °C | - |
| Zone 2 | **285 - 305** | °C | - |
| Zone 3 | **290 - 310** | °C | - |
| Nozzle temperature | **285 - 305** | °C | - |
| Screw speed | **40 - 70** | rpm | - |
| Back pressure | **1 - 4** | MPa | - |

## Characteristics

**Processing**
Injection Molding

**Applications**
Electrical and Electronical, General Purpose

**Special Characteristics**
High impact or impact modified

**Regional Availability**
North America, Europe, Asia Pacific, South and Central America

**Chemical Resistance**
General Chemical Resistance