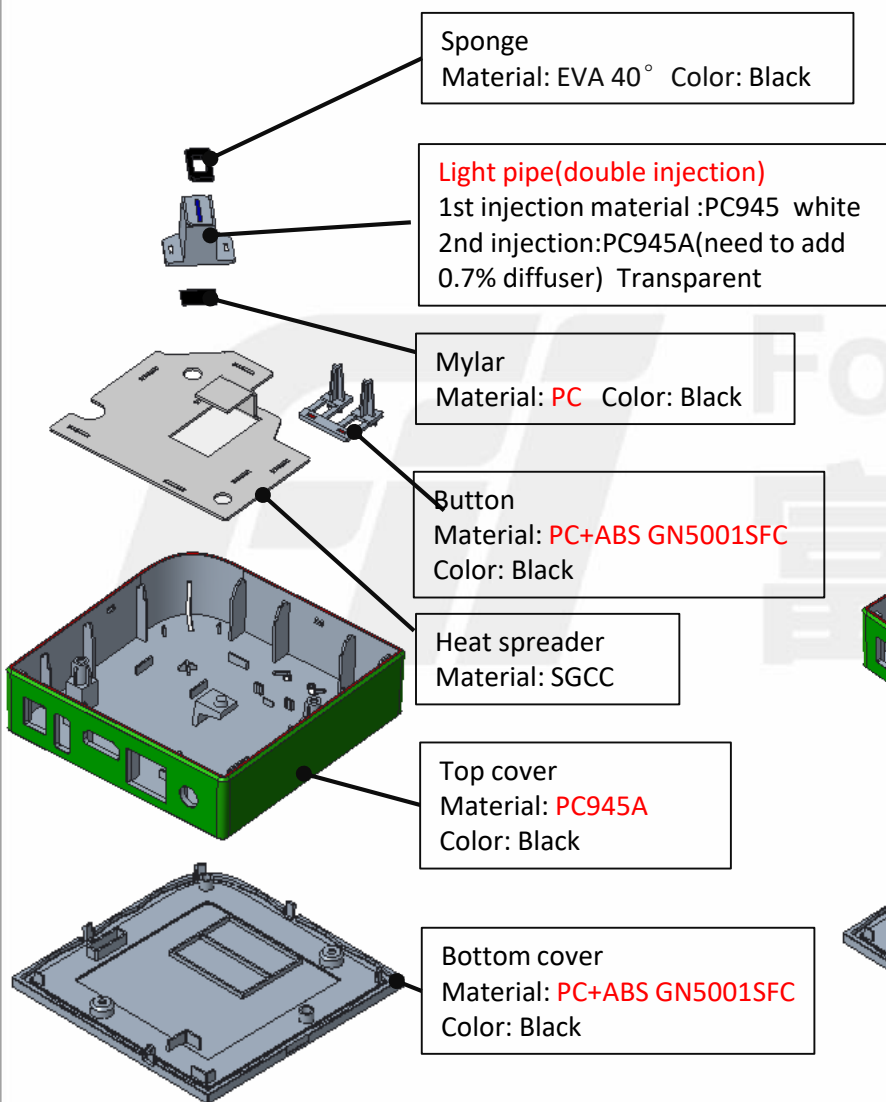


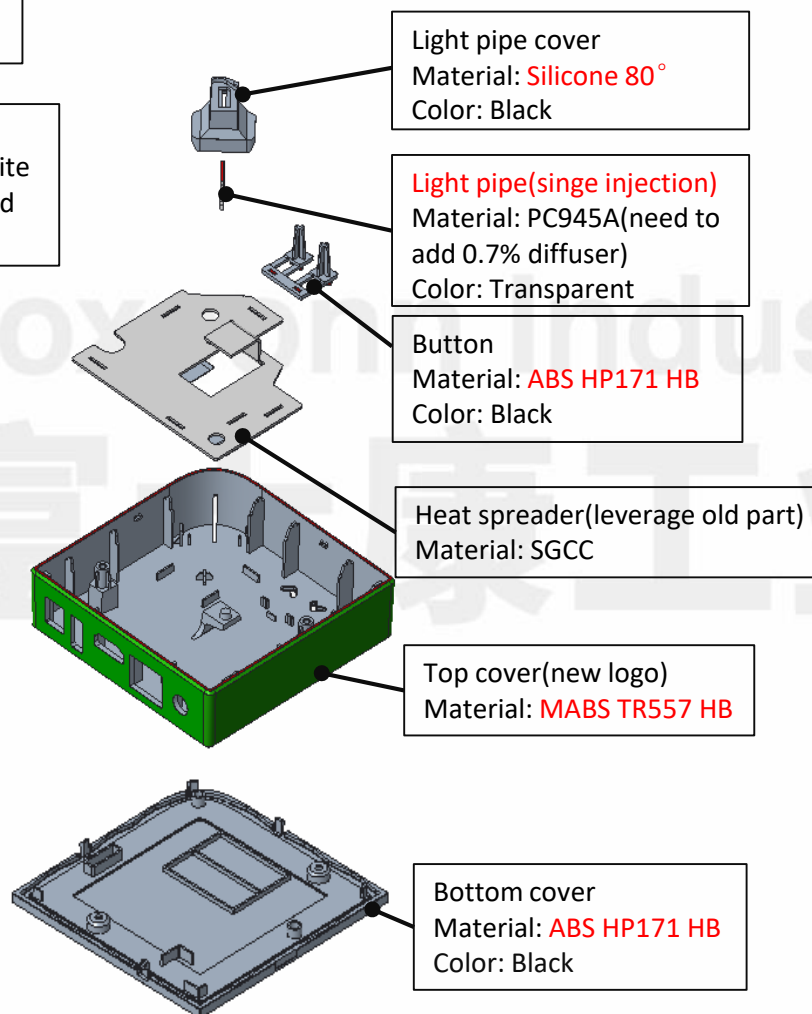


Comparison of new housing and old housing

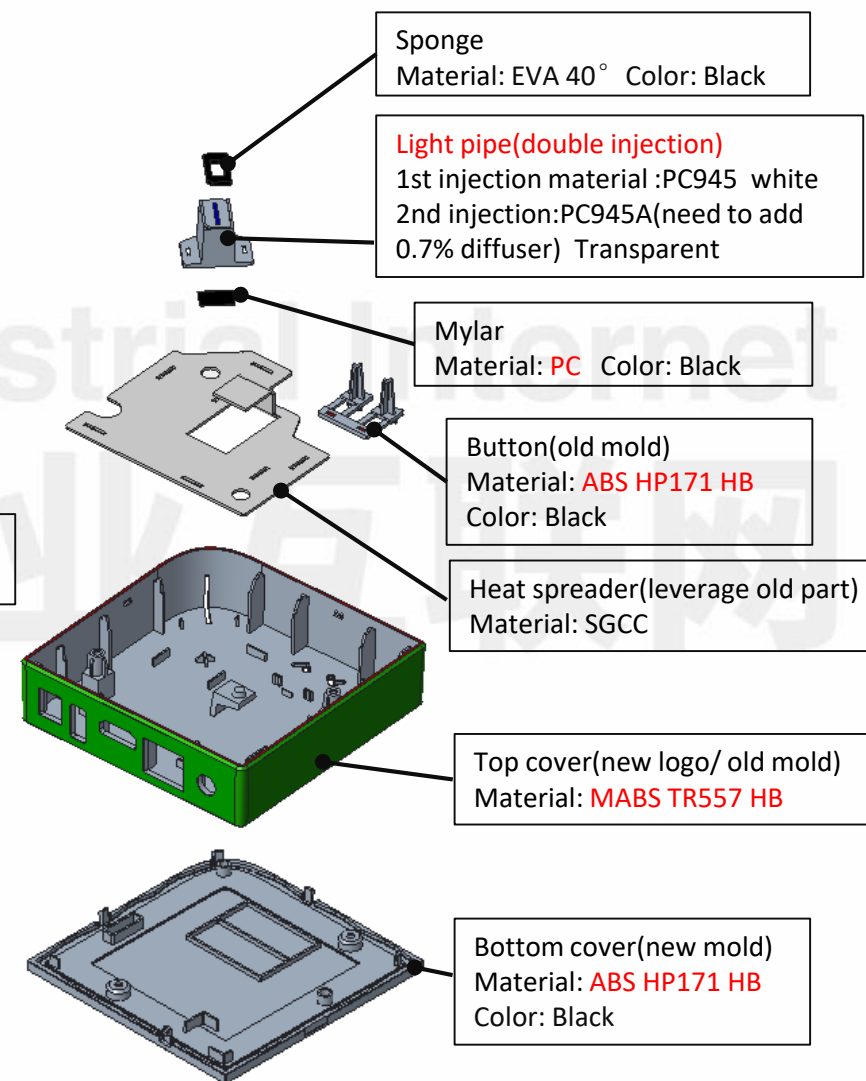
Old housing



New housing

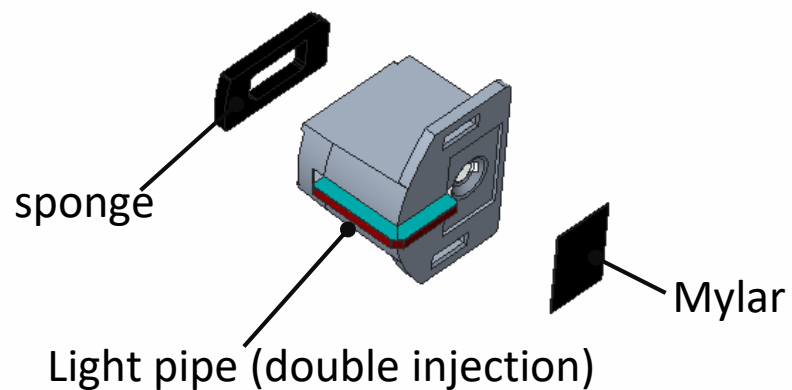
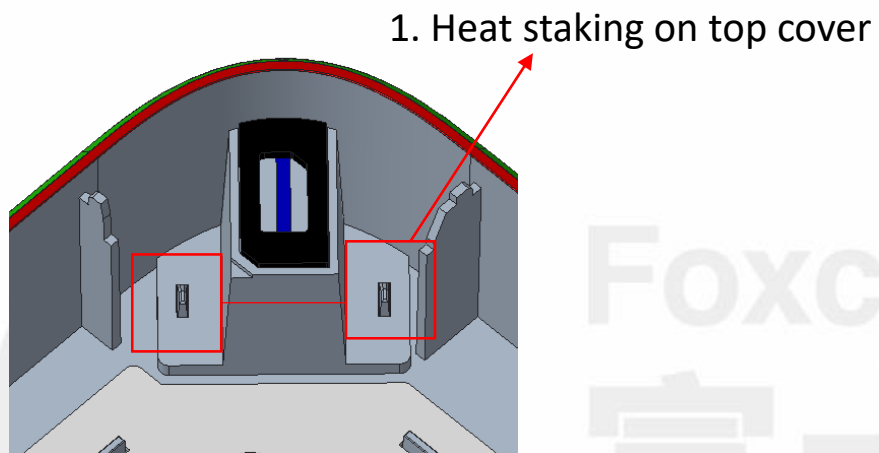


Apr+May housing



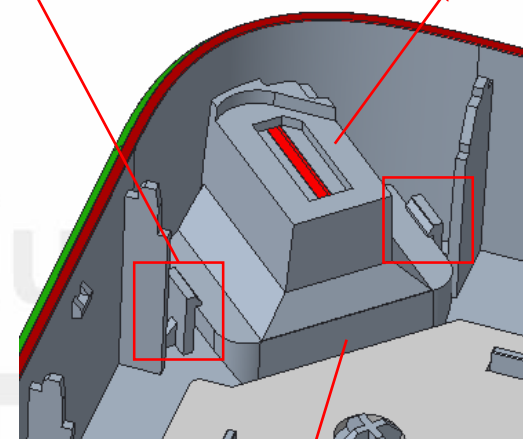
Old Light pipe

Use old light pipe for Apr+May shipment

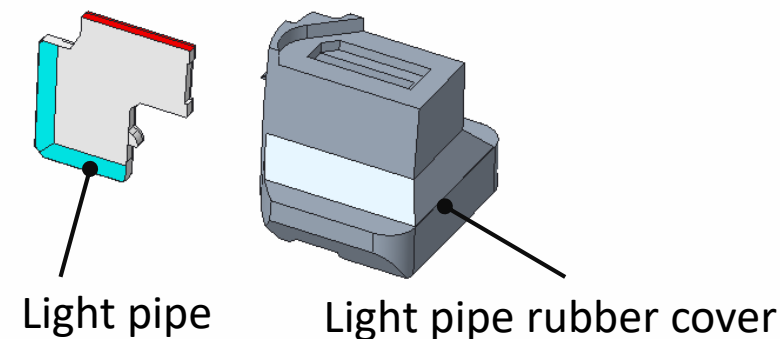


New Light pipe

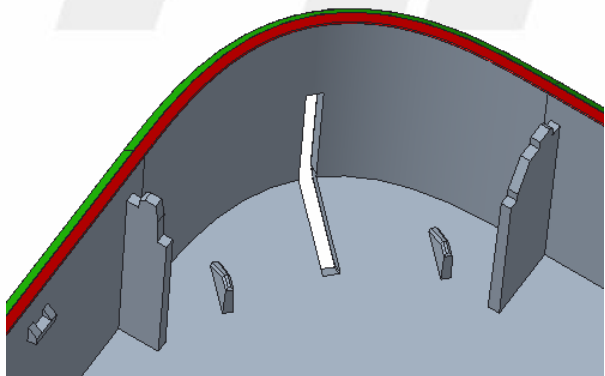
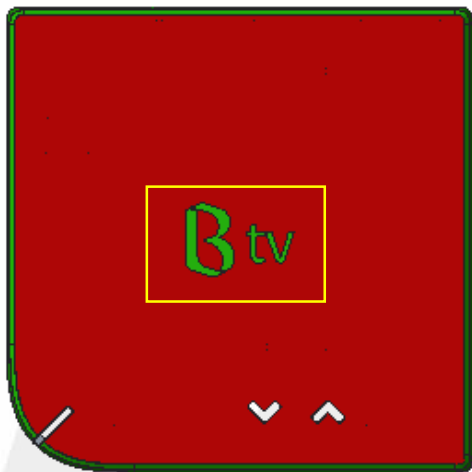
1. Top cover add hooks to fix rubber.
2. This surface is pressed by PCBA.



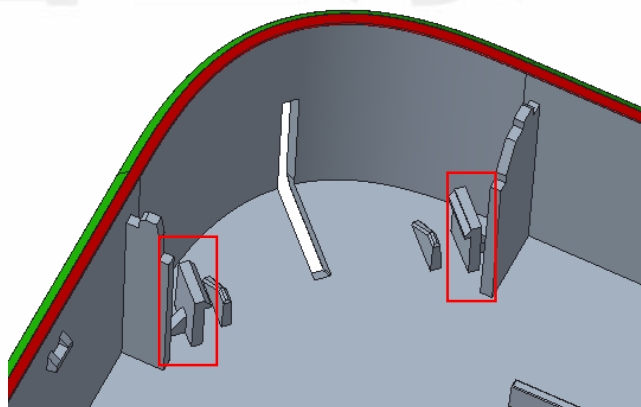
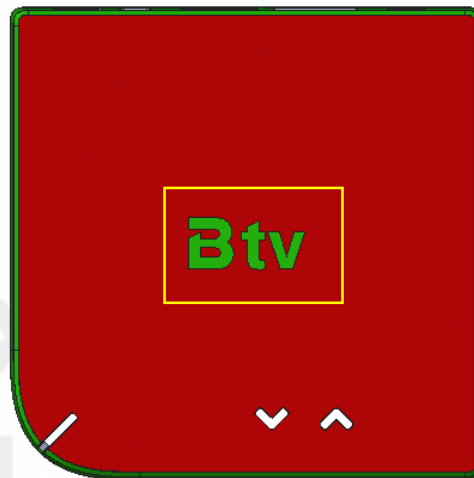
3. This surface is pressed by side surface of heat spreader.



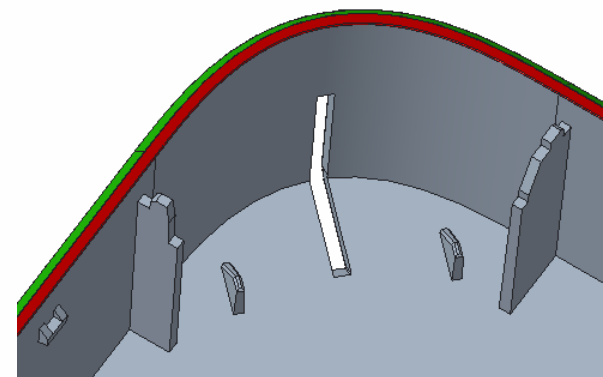
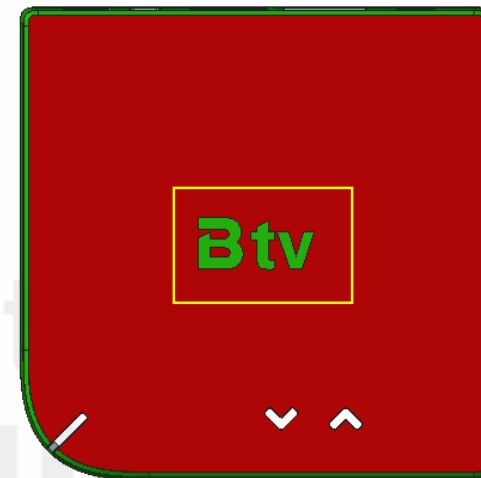
Old top cover



New top cover



Apr+May top cover



PC 945A						MABS TR557					
TYPICAL PROPERTIES ¹		Test Condition	TYPICAL VALUE	UNIT	STANDARD	TYPICAL PROPERTIES ¹		Test Condition	TYPICAL VALUE	UNIT	STANDARD
PROCESSING PARAMETERS Injection Molding	Drying Temperature		120	°C	-	PROCESSING PARAMETERS Injection Molding	Drying Temperature		80~90	°C	-
	Drying Time		2~4	hrs	-		Drying Time		2 ~ 4	hrs	-
	Maximum Moisture Content		0.02	%	-		Maximum Moisture Content		0.1	%	-
	Melt Temperature		280 - 310	°C	-		Melt Temperature		190 ~ 220	°C	-
	Nozzle Temperature		270 - 290	°C	-		Nozzle Temperature		190 ~ 220	°C	-
	Rear - Zone 1 Temperature	Rear	260 - 280	°C	-		Cylinder Temperature Rear	Rear	180 ~ 200	°C	-
	Middle - Zone 2 Temperature	Middle	270 - 290				Cylinder Temperature Middle	Middle	190 ~ 210		
	Front - Zone 3 Temperature	Front	280 - 310				Cylinder Temperature Front	Front	200 ~ 220		
	Mold Temperature		80 - 110	°C	-		Mold Temperature		40 ~ 60	°C	-
MECHANICAL	Tensile Stress, yld, Type I	50 mm/min	630	kgf/cm ²	ASTM D 638	MECHANICAL	Tensile Strength, 3.2mm @ Yield	50mm/min	2 470	kg/cm	ASTM D638
	Tensile Strain, brk, Type I	50 mm/min	125	%	ASTM D 638		Tensile Elongation, 3.2mm @ Break	50mm/min	30	%	ASTM D638
	Flexural Stress, yld	1.3 mm/min, 50 mm span	1020	kgf/cm ²	ASTM D 790		Flexural Strength, 3.2mm	15mm/min	2 700	kg/cm	ASTM D790
	Flexural Modulus	1.3 mm/min, 50 mm span	24100	kgf/cm ²	ASTM D 790		Flexural Modulus, 3.2mm	15mm/min	2 22,000	kg/cm	ASTM D790
	Tensile Modulus	50 mm/min	23100	kgf/cm ²	ASTM D 638		IZOD Impact Strehgth, 6.4mm (Notched)	23°C	17	kg-cm/cm	ASTM D256
	Tensile Stress, brk, Type I	50 mm/min	680	kgf/cm ²	ASTM D 638		IZOD Impact Strehgth, 3.2mm (Notched)	23°C	17	kg-cm/cm	ASTM D256
	Tensile Strain, yld, Type I	50 mm/min	6	%	ASTM D 638		Rockwell Hardness	R-Scale	107	-	ASTM D785
PHYSICAL	Specific Gravity	-	1.19	-	ASTM D 792	PHYSICAL	Specific Gravity	-	1.09	-	ASTM D792
	Mold Shrinkage, flow, 3.2 mm (5)		0.6 - 0.8	%	SABIC Method		Melt Flow Rate	220°C/10kg	21	g/10min	ASTM D1238
	Melt Flow Rate, 300°C/1.2 kgf		10	g/10 min	ASTM D 1238						
Thermal	HDT, 0.45 MPa, 3.2 mm, unannealed		137	°C	ASTM D 648	Thermal	Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	81	°C	ASTM D648
Optical	Light Transmission, 2.54 mm		>85	%	ASTM D 1003	Optical	Transparency		90	%	ASTM D 1003
FLAME CHARACTERISTICS	UL Recognized, 94V-2 Flame Class Rating (3)		1.52	mm	UL 94	FLAME CHARACTERISTICS	UL Recognized, HB		1.5	mm	UL 94
	UL Recognized, 94V-0 Flame Class Rating (3)		3.04	mm	UL 94		UL Recognized, HB		3	mm	UL 94

PC 945A

TYPICAL PROPERTIES ¹		TYPICAL VALUE	UNIT
PROCESSING PARAMETERS Injection Molding	Drying Temperature	120	°C
	Drying Time	2~4	hrs
	Maximum Moisture Content	0.02	%
	Melt Temperature	280 - 310	°C
	Nozzle Temperature	270 - 290	°C
	Rear - Zone 1 Temperature	260 - 280	°C
	Middle - Zone 2 Temperature	270 - 290	
	Front - Zone 3 Temperature	280 - 310	
	Mold Temperature	80 - 110	°C

MABS TR557

TYPICAL PROPERTIES ¹		TYPICAL VALUE	UNIT
PROCESSING PARAMETERS Injection Molding	Drying Temperature	80~90	°C
	Drying Time	2 ~ 4	hrs
	Maximum Moisture Content	0.1	%
	Melt Temperature	190 ~ 220	°C
	Nozzle Temperature	190 ~ 220	°C
	Cylinder Temperature Rear	180 ~ 200	°C
	Cylinder Temperature Middle	190 ~ 210	
	Cylinder Temperature Front	200 ~ 220	
	Mold Temperature	40 ~ 60	°C

Top cover(old)

Material: **PC945A**



945A_data sheet



945A-UL

Top cover(new)

Material: **MABS TR557 HB**



MABS TR557



TR557(m) UL

Bottom cover/Button(old)

Material: **PC+ABS GN5001SFC**



LUPOY
GN5001SFC 物性表



LUPOY
GN5001SFC(UL) ULp

Bottom cover/Button(new)

Material: **ABS HP171 HB**



ABS HP171



UL Yellow
Card?HP171

Light pipe(double injection)

1st injection material :PC945 white

2nd injection:PC945A(need to add 0.7%
diffuser) Transparent



945A_data sheet



945A-UL



945_data sheet



LEXAN 945 UL
Card

Light pipe(singe injection)

Material: PC945A(need to add 0.7% diffuser)

Color: Transparent



945A_data sheet



945A-UL