

Lupoy® GP1006FM

Polycarbonate

LG Chem Ltd.

Message:

Description

Flame Retardant

Application

IT/OA, E&E Housing and Components

General Information			
UL YellowCard	E67171-248609	E67171-301077	E248280-322194
	E353371-101107328		
Features	Flame Retardant		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	118		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	61.8	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 ⁴ (Yield, 3.20 mm)	98.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	780	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	130	°C	ASTM D648
Vicat Softening Temperature	141	°C	ASTM D1525 ⁶
RTI Elec	120	°C	UL 746
RTI Imp	110	°C	UL 746
RTI Str	120	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.00 mm	V-0		
1.50 mm	V-0		

V-0

2.50 mm

5VA

V-0

3.00 mm

5VA

Injection	Nominal Value	Unit
Drying Temperature	100 to 120	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	260 to 280	°C
Middle Temperature	280 to 300	°C
Front Temperature	300 to 320	°C
Nozzle Temperature	300 to 320	°C
Processing (Melt) Temp	300 to 320	°C
Mold Temperature	80.0 to 120	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	
5.	18.6kg	
6.	Rate A (50°C/h), Loading 2 (50 N)	

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