Lupoy® GP5100

Polycarbonate + ABS

LG Chem Ltd.

Message:

Lupoy® GP5100 is a Polycarbonate + ABS (PC+ABS) material filled with 10% glass fiber. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding. Typical applications include: Automotive Electrical/Electronic Applications Housings

UL VellowCardEG1711-248451E248280-322217Filler / ReinforcementGlass Fiber 10% Filler by WeightFeaturesGeneral PurposeUsesAutomotive Instrument PanelElectrical Housing Electrical/Electronic Applications General PurposeProcessing MethodInjection MoldingProcessing MethodInjection MoldingPhysicalNominal ValueUnitTest Methodg/cm³ASTM D792Methoss-Flow Rate (MFR) (250°C/216 Kg)4.0g/10 minASTM D793Methodss-Flow Rate (MFR) (250°C/216 Kg)0.30 to 0.40%ASTM D793Method0.30 to 0.40%ASTM D1238Molding Shrinkage - Flow (3.20 mm)0.30 to 0.40%ASTM D638Tensile Elengation 2 (Break, 3.20 mm)6.0%ASTM D638Flexural Modulus 3 (3.20 mm)6.0%ASTM D638Flexural Modulus 4 (3.20 mm)137MPaASTM D790ImpactNominal ValueUnitTest MethodNotchel Izod Impact (37°C, 3.20 mm)98//mASTM D55ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (18 MPa, Unannealed, 6.40 mm)Nominal ValueUnitMereinS.00 o 9.0//mASTM D56ThermalNominal ValueUnitTest MethodDeflection Temperature Under Load (18 MPa, Unannealed, 6.40 mm)Nominal ValueUnitMPa, Unannealed, 6.40 mm)121"CASTM D648MPa, Unannealed, 6.40 mm)121	General Information			
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Drying Time3.0 to 5.0hrSuggested Max Moisture0.020%Rear Temperature220 to 240°C	Injection	Nominal Value	Unit	
Suggested Max Moisture0.020%Rear Temperature220 to 240°C	Drying Temperature	85.0 to 95.0	°C	
Rear Temperature 220 to 240 °C	Drying Time	3.0 to 5.0	hr	
	Suggested Max Moisture	0.020	%	
Middle Temperature 235 to 255 °C	Rear Temperature	220 to 240	°C	
	Middle Temperature	235 to 255	°C	

Front Temperature	250 to 265	°C
Nozzle Temperature	250 to 265	°C
Processing (Melt) Temp	235 to 265	°C
Mold Temperature	50.0 to 80.0	°C
Back Pressure	0.0196 to 0.0588	MPa
Screw Speed	40 to 70	rpm
NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	

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