

Lupox® HI1002F

Polycarbonate + PBT

LG Chem Ltd.

Message:

Description

Flame Retardant, High Impact

Application

IT/OA, E&E(Switch)

General Information			
UL YellowCard	E67171-248578	E248280-533894	E353371-101107258
Features	Flame Retardant		
	High Impact Resistance		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.90 to 1.3	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.080	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	49.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 50	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1960	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	72.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	90.0	°C	ASTM D648
Peak Melting Temperature	223	°C	ASTM D3418
RTI Elec	130	°C	UL 746
RTI Imp	120	°C	UL 746
RTI Str	120	°C	UL 746
Electrical	Nominal Value	Test Method	
Arc Resistance	PLC 5	ASTM D495	
Comparative Tracking Index (CTI) ⁵	PLC 2	UL 746	
Flammability	Nominal Value	Test Method	
Flame Rating	UL 94		
0.750 mm	V-0		

1.50 mm	V-0
2.00 mm	V-0
	V-0
2.30 mm	5VA
	V-0
3.00 mm	5VA

Injection	Nominal Value	Unit
Drying Temperature	100 to 120	°C
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	240 to 245	°C
Middle Temperature	245 to 250	°C
Front Temperature	250 to 255	°C
Nozzle Temperature	250 to 265	°C
Processing (Melt) Temp	250 to 265	°C
Mold Temperature	40.0 to 80.0	°C

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	2.8 mm/min	
4.	2.8 mm/min	
5.	Solution A	

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