

Lupoy® GP5056F

Polycarbonate + ABS

LG Chem Ltd.

Message:

Description

Flame Retardance, General Purpose

Application

IT/OA(Housing)

General Information			
UL YellowCard	E302314-530049	E67171-248453	E248280-322219
	E302314-100696534	E353371-101107250	
Filler / Reinforcement	Glass Fiber,5.0% Filler by Weight		
Features	Flame Retardant		
	General Purpose		
Uses	Electrical Housing		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (260°C/2.16 kg)	2.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.35 to 0.55	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	70.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	6.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	3330	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	113	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	54	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	110	°C	ASTM D648
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
2.50 mm	V-0		
3.00 mm	V-0		
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	

Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	< 0.020	%
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. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 10 mm/min |
| 4. | 10 mm/min |
| 5. | 18.6kg |

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