

Lupoy® GN5201F

Polycarbonate + ABS

LG Chem Ltd.

Message:

Description

Halogen Free Flame Retardant, High Stiffness

Application

E&E(Housing, OA Frame)

General Information			
UL YellowCard	E67171-248444	E67171-248449	E248280-533895
	E353371-101107244	E353371-101273003	
Filler / Reinforcement	Mineral,20% Filler by Weight		
Features	Flame Retardant		
	Halogen Free		
	High Stiffness		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	103	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	5880	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	147	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	110	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	105	°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	
1.50 mm	V-0		
2.00 mm	V-0		
2.00 mm, Black	5VB		

Injection	Nominal Value	Unit
Drying Temperature	75.0 to 85.0	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	< 0.040	%
Rear Temperature	230 to 250	°C
Middle Temperature	245 to 265	°C
Front Temperature	260 to 275	°C
Nozzle Temperature	260 to 275	°C
Processing (Melt) Temp	245 to 275	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure	0.981 to 1.96	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 |
| 5. | 18.6kg |

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