

Lupoy® GN1002FL

Polycarbonate

LG Chem Ltd.

Message:

Description
Halogen Free Flame Retardant, High Flow, High Impact
Application
IT/OA (M/P Battery Inner Pack Housing)

General Information			
UL YellowCard	E248280-100158639	E302314-530024	E67171-248605
Features	E353371-101107240		
	Flame Retardant		
	Halogen Free		
	High Flow		
	High Impact Resistance		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	60.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2290	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	92.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	115	°C	ASTM D648
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating		UL 94	
1.50 mm	V-0		

V-0

2.00 mm

5VB

Injection	Nominal Value	Unit
Drying Temperature	90.0 to 100	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	270 to 285	°C
Middle Temperature	275 to 290	°C
Front Temperature	275 to 290	°C
Nozzle Temperature	270 to 285	°C
Processing (Melt) Temp	275 to 290	°C
Mold Temperature	80.0 to 100	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 80	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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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