SolutionPartner

LG Chem

LUPOY GP5100

Injection Molding Grade, PC/ABS+GF10%

Description

General Purpose, GF Reinforced

Application

Electrical Appliance Housing, Automotive I/P

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.16~1.20
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.3 ~ 0.4
Melt Flow Rate	250℃/2.16kg	ASTM D1238	g/10min	4
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm^2	900
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	3
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	1,400
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	49,000
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	10
	-30℃		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	125
	4.6kg		℃	
Vicat Softening Temperature		ASTM D1525		
	5kg, 50℃/h		℃	
Ball Pressure Temperature		IEC 60695-10-2	℃	
Flammability		UL94		
0.7mm			class	
1.2mm			class	
1.7mm			class	
3.0mm			class	
Relative Temperature Index		UL 746B		
Electrical			℃	
Mechanical with Impact			℃	
Mechanical without Impact			℃	

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.
Values given should not be interpreted as specification and not be used for part or tool design.
All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : Jul-09, 2014

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Electrical

Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts
Surface Resistivity		IEC 60093	Ohm
Volume Resistivity	23℃	ASTM D257	Ohm·m
Arc Resistance	23℃	ASTM D495	Ohm·cm
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm
Dielectric Constant (10^6 Hz)	23℃	ASTM D150	sec

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	85 ~ 95
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		℃	235 ~ 265
Cylinder Temperature	Rear	℃	220 ~ 240
	Middle	℃	235 ~ 255
	Front	℃	250 ~ 265
Nozzle Temperature		℃	250 ~ 265
Mold Temperature		℃	50 ~ 80
Back Pressure		kg/cm^2	
Screw Speed		rpm	40 ~ 70

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.
These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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