SolutionPartner

LG Chem

LUPOY GN2101FA

Injection Molding, PC+GF10%

Description

Halogen Free Flame Retardant
Mold release

Application

IT/OA, E&E Housing and Components

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ISO 1183	kg/m^3	1.3
Molding Shrinkage (Flow), 3.2mm		LG Method	%	0.2~0.4
Melt Flow Index	300℃/1.2kg	ISO 1133	g/10min	9
Mechanical				
Tensile Modulus		ISO 527		
@ Yield	1mm/min		MPa	3 800
Tensile Strength		ISO 527		
@ Yield	50mm/min		MPa	74
Tensile Strain		ISO 527		
@ Break	50mm/min		%	3
Flexural Strength	2mm/min	ISO 178	MPa	117
Flexural Modulus	2mm/min	ISO 178	MPa	3 800
Charpy Impact Strength		ISO 179		
(Notched)	23℃		kJ/m^2	9
	-30℃		kJ/m^2	6
IZOD Impact Strength, 3.2mm		ISO 180		
(Notched)	23℃		kJ/m^2	8
	-30℃		kJ/m^2	5
Thermal				
Heat Deflection Temperature, 4.0mm		ISO 75		
(Unannealed)	1.8MPa		℃	131
	0.45MPa		℃	
Vicat Softening Temperature		ISO 306		
	50N, 50℃/h		℃	145
Flammability		UL94	Thickness	
V-0			mm	1.5
5VA			mm	3.0
Relative Temperature Index		UL 746B		
Electrical			℃	120
Mechanical with Impact			℃	90
Mechanical without Impact			℃	105

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 : May, 2017

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100 ~ 120
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		℃	300 ~ 340
Cylinder Temperature	Rear	℃	270 ~ 300
	Middle	℃	280 ~ 310
	Front	℃	290 ~ 330
Nozzle Temperature		℃	290 ~ 330
Mold Temperature		℃	90 ~ 120
Back Pressure		kg/cm^2	10 ~ 40
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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