SolutionPartner

LG Chem

LUPOY GP1000L

Injection Molding Grade, PC

Description

General purpose, Transparent

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ISO 1183	kg/m^3	1,200
Molding Shrinkage (Flow), 3.2mm		LG Method	%	0.5~0.8
Melt Flow Index	250℃/2.16kg	ISO 1133	g/10min	
Melt Flow Index	260℃/5.0kg	ISO 1133	g/10min	
Melt Flow Index	300℃/1.2kg	ISO 1133	g/10min	22
Melt Flow Index	300℃/2.16kg	ISO 1133	g/10min	
Mechanical				
Tensile Modulus		ISO 527		
@ Yield	1mm/min		MPa	2,320
Tensile Strength		ISO 527		
@ Yield	50mm/min		MPa	60
Tensile Strain		ISO 527		
@ Break	50mm/min		%	130
Flexural Strength	2mm/min	ISO 178	MPa	91
Flexural Modulus	2mm/min	ISO 178	MPa	2,240
Charpy Impact Strength		ISO 179		
	23℃		kJ/m^2	NB
	-30℃		kJ/m^2	83
Charpy Impact Strength		ISO 179		
(Notched)	23℃		kJ/m^2	63
	-30℃		kJ/m^2	12
IZOD Impact Strength, 6.4mm		ISO 180		
(Notched)	23℃		kJ/m^2	60
	-30℃		kJ/m^2	12
Thermal				
Heat Deflection Temperature, 6.4mm		ISO 75		
(Unannealed)	1.8MPa		℃	125
	0.45MPa		℃	
Vicat Softening Temperature		ISO 306		
	50N, 50℃/h		℃	142
Flammability		UL94	Thickness	
HB			mm	1.5
V-0			mm	
5VA			mm	
5VB			mm	

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 : April-1, 2011

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100 ~ 120
Drying Time		hrs	3 ~ 5
Minimum Moisture Content		%	0.02
Melt Temperature		℃	300 ~ 320
Cylinder Temperature	Rear	℃	260 ~ 280
	Middle	℃	280 ~ 300
	Front	℃	300 ~ 320
Nozzle Temperature		℃	300 ~ 320
Mold Temperature		℃	80 ~ 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.

Updated : April-1, 2011