

LUPOY GP5008BF

Injection Molding, FR PC/ABS

Description

Flame Retardance, Heat Resistance

Application

E&E(Housing)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.18
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4 ~ 0.6
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	6
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	550
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	50
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	840
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	22,500
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23 °C		kg·cm/cm	53
	-30 °C		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	113
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		°C	110
	4.6kg		°C	
Vicat Softening Temperature		ASTM D1525		
	5kg, 50 °C/h		°C	
Flammability		UL94		
0.7mm			class	
1.2mm			class	
1.5mm			class	V0
3.0mm			class	V0
Relative Temperature Index		UL 746B		
Electrical			°C	85
Mechanical with Impact			°C	65
Mechanical without Impact			°C	70

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 moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : Apr-09, 2015

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	75 ~ 85	
Drying Time	hrs	3 ~ 5	
Maximum Moisture Content	%	0.02	
Melt Temperature	°C	235 ~ 265	
Cylinder Temperature	Rear	°C	220 ~ 240
	Middle	°C	235 ~ 255
	Front	°C	250 ~ 265
Nozzle Temperature	°C	250 ~ 265	
Mold Temperature	°C	50 ~ 80	
Back Pressure	kg/cm ²	0.2 ~ 0.6	
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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