

Lupoy® HI1002ML

Polycarbonate

LG Chem Ltd.

Message:

Description

General Purpose, High Impact, Chemical Resistance

Application

Mobile Phone Housing

General Information			
UL YellowCard	E67171-248617	E248280-322190	
Features	General Purpose		
	Good Chemical Resistance		
	High Impact Resistance		
Uses	Cell Phones		
	Electrical Housing		
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)	13	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	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)	56.9	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	130	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2260	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	200	J/m	
23°C, 3.20 mm	740	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	130	°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
1.60 mm	HB	
3.00 mm	V-2	
Injection	Nominal Value	Unit
Drying Temperature	100 to 110	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	275 to 290	°C
Middle Temperature	285 to 305	°C
Front Temperature	290 to 310	°C
Nozzle Temperature	285 to 305	°C
Processing (Melt) Temp	290 to 310	°C
Mold Temperature	80.0 to 110	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	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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