

Lupoy® GP2100

Polycarbonate

LG Chem Ltd.

Message:

Description

General Purpose, Heat Resistance

Application

IT/OA, E&E Housing and Components, Automotive (Interior)

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	General Purpose		
	Medium Heat Resistance		
Uses	Automotive Interior Parts		
	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	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)	0.20 to 0.40	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	124		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	78.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	3.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	3530	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	127	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	140	°C	ASTM D648
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	3.0 to 5.0	hr	
Suggested Max Moisture	< 0.020	%	

Rear Temperature	270 to 300	°C
Middle Temperature	280 to 310	°C
Front Temperature	290 to 330	°C
Nozzle Temperature	290 to 330	°C
Processing (Melt) Temp	300 to 340	°C
Mold Temperature	90.0 to 120	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm

NOTE

1.	5.0 mm/min
2.	5.0 mm/min
3.	1.3 mm/min
4.	1.3 mm/min
5.	18.6kg

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