

Lupoy® GN1004FA

Polycarbonate

LG Chem Ltd.

Message:

Description
Halogen Free Flame Retardant, Chemical Resistance, High Impact at Low Temperature
Applications
IT/OA Housing and Components

General Information			
UL YellowCard	E67171-475839	E248280-100040974	E353371-101107269
Additive	Flame retardancy		
Features	Impact resistance, high		
	Good chemical resistance		
	Halogen-free		
	Flame retardancy		
Uses	Shell		
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)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 - 0.80	%	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)	54.9	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2160	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	290	J/m	ASTM D256
23°C, 3.20 mm	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	129	°C	ASTM D648
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI	80.0	°C	UL 746
Flammability	Nominal Value		Test Method

Flame Rating (1.50 mm)	V-0	UL 94
Injection	Nominal Value	Unit
Drying Temperature	100 - 110	°C
Drying Time	3.0 - 5.0	hr
Rear Temperature	275 - 290	°C
Middle Temperature	285 - 305	°C
Front Temperature	290 - 310	°C
Nozzle Temperature	285 - 305	°C
Processing (Melt) Temp	290 - 310	°C
Mold Temperature	80.0 - 110	°C
Back Pressure	0.981 - 3.92	MPa
Screw Speed	40 - 70	rpm
Injection instructions		
Minimum Moisture Content: 0.02%		
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

