

LUPOY GN2503FT

Injection Molding Grade, PC + Glass fiber Reinforced

Description

High Stiffness
Halogen Free Flame Retardent

Application

IT/OA(Notebook PC Housing)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.65
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.15
Melt Flow Rate	260℃, 5kg	ASTM D1238	g/10min	10
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	5mm/min		kg/cm ²	1,400
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	2,150
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	140,000
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	11
	-30℃		kg·cm/cm	
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	92
	4.6kg		℃	
Vicat Softening Temperature	5kg, 50℃/h	ASTM D1525	℃	
Flammability		UL94		
	0.8mm		class	V0
	1.0mm		class	V0
	2.5mm		class	
	3.0mm	class	V0	
Relative Temperature Index		UL 746B		
	Electrical		℃	80
	Mechanical with Impact		℃	80
	Mechanical without Impact		℃	80

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℃, 50% relative humidity.

Updated : Aug-1, 2014

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Electrical

Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts
Surface Resistivity		IEC 60093	Ohm
Volume Resistivity	23℃	ASTM D257	Ohm·m
Arc Resistance	23℃	ASTM D495	Ohm·cm
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm
Dielectric Constant (10 ⁶ Hz)	23℃	ASTM D150	sec

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	85 ~ 90
Drying Time		hrs	3 ~ 5
Minimum Moisture Content		%	0.04
Melt Temperature		℃	270 ~ 320
Cylinder Temperature	Rear	℃	270 ~ 290
	Middle	℃	280 ~ 310
	Front	℃	290 ~ 320
Nozzle Temperature		℃	290 ~ 320
Mold Temperature		℃	60 ~ 100
Back Pressure		kg/cm ²	10 ~ 20
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 : May-1, 2012

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