

LUPOY GN5007FH

Injection Molding, PC/ABS

Description

Halogen Free Flame Retardant, Heat resistance

Application

IT/OA, Electric & Electronic housing and Components

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.19
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5 ~ 0.8
Melt Flow Rate	260 /5kg	ASTM D1238	g/10min	16
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	650
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	100
Tensile Modulus, 3.2mm	50mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	970
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	22,000
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23		kg-cm/cm	65
	-30		kg-cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg			128
	4.6kg			
Vicat Softening Temperature		ASTM D1525		
	5kg, 50 /h			
Ball Pressure Temperature		IEC 60695-10-2		
Burning Rate, 3.2mm		FMVSS 302	mm	
Flammability		UL94		
0.7mm			class	
1.5mm			class	V-0
2.5mm			class	
3.0mm			class	V-0
Relative Temperature Index		UL 746B		
Electrical				95
Mechanical with Impact				90
Mechanical without Impact				95

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 molded specimens and after 48 hours storage at 23 , 50% relative humidity.

Updated : Mar-22, 2012

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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		90~ 100
Drying Time	hrs	3 ~ 5
Minimum Moisture Content	%	0.02
Melt Temperature		285 ~ 315
Cylinder Temperature	Rear	260 ~ 280
	Middle	270 ~ 300
	Front	270 ~ 300
Nozzle Temperature		280 ~ 310
Mold Temperature		60 ~ 100
Back Pressure	kg/cm ²	10~40
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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