

LUPOY GP2102

Injection molding , PC+10%GF

Description

General purpose, Good Toughness, Chemical Resistance

Application

Mobile Phone Housing

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.25
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.2 ~ 0.4
Melt Flow Rate	3000 /1.2 kg	ASTM D1238	g/10min	10
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	560
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	20
@ Break	50mm/min		%	
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	1,100
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	33,000
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23		kg-cm/cm	30
	-30		kg-cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	124
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg			137
	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		
0.75mm			class	HB
1.5mm			class	
2.5mm			class	
3.2mm			class	
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 molded specimens and after 48 hours storage at 23 , 50% relative humidity.

Updated : Nov-09, 2009

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Electrical

Property	Solution A	Standard	Unit
Comparative Tracking Index(CTI)		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 (Extrusion Molding)

Processing Parameters	Unit	Value
干燥温度		100~120
干燥时间	hrs	3~5
最少含水量	%	0.02
熔融温度		295~325
注塑机炮筒温度	后部	280~300
	中部	285~310
	前部	290~320
射嘴温度		290~320
模温		90~120
被压	kg/cm ²	10~40
螺杆转速	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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