

LUPOY GN5001RFG

Injection Molding Grade, PC/ABS

Description

Halogen-free flame flame retardant, Low shrinkage

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ISO 1183	kg/m ³	1,190
Molding Shrinkage (Flow), 3.2mm		LG Method	%	0.4~0.6
Melt Flow Index	250 °C/2.16kg	ISO 1133	g/10min	20
Melt Flow Index	260 °C/5.0kg	ISO 1133	g/10min	
Melt Flow Index	300 °C/1.2kg	ISO 1133	g/10min	
Melt Flow Index	300 °C/2.16kg	ISO 1133	g/10min	
Mechanical				
Tensile Modulus @ Yield	1mm/min	ISO 527	MPa	2,500
Tensile Strength @ Yield	50mm/min	ISO 527	MPa	62
Tensile Strain @ Break	50mm/min	ISO 527	%	>20
Flexural Strength	2mm/min	ISO 178	MPa	93
Flexural Modulus	2mm/min	ISO 178	MPa	2,600
Charpy Impact Strength	23 °C -30 °C	ISO 179	kJ/m ² kJ/m ²	NB
Charpy Impact Strength (Notched)	23 °C -30 °C	ISO 179	kJ/m ² kJ/m ²	15
IZOD Impact Strength, 6.4mm (Notched)	23 °C -30 °C	ISO 180	kJ/m ² kJ/m ²	13
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	1.8MPa 0.45MPa	ISO 75	°C °C	91
Vicat Softening Temperature	50N, 50 °C/h	ISO 306	°C	99
Flammability		UL94	Thickness	
HB			mm	
V-0			mm	1.2
5VA			mm	2.5
5VB			mm	1.5

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 °C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	75 ~ 85
Drying Time		hrs	3 ~ 5
Minimum Moisture Content		%	0.02
Melt Temperature		℃	235 ~ 265
Cylinder Temperature	Rear	℃	220 ~ 240
	Middle	℃	235 ~ 255
	Front	℃	250 ~ 265
Nozzle Temperature		℃	250 ~ 265
Mold Temperature		℃	50 ~ 80
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.