

LUPOY GP5206F

(PC+ABS)-GF20

LG Chem

| Processing/Physical Characteristics | Value | Unit | Test Standard |
|-------------------------------------|-------|---------|---------------|
| ASTM Data | | | |
| Melt Flow Index, MFI | 3 | g/10min | ASTM D 1238 |
| Temperature | 250 | °C | - |
| Load | 2.16 | kg | - |
| Mold Shrinkage, MD | 0.002 | mm/mm | ASTM D 955 |

| Mechanical properties | Value | Unit | Test Standard |
|-----------------------------|-------|------|---------------|
| ASTM Data | | | |
| Tensile Strength at Yield | 93.2 | MPa | ASTM D 638 |
| Elongation at Break | 4 | % | ASTM D 638 |
| Flexural Modulus | 5690 | MPa | ASTM D 790 |
| Flexural Strength | 137 | MPa | ASTM D 790 |
| Rockwell Hardness | R 117 | - | ASTM D 785 |
| Izod Impact notched, 1/8 in | 66 | J/m | ASTM D 256 |

| Thermal properties | Value | Unit | Test Standard |
|--------------------|-------|------|---------------|
| ASTM Data | | | |
| UL 94 Flame rating | V-0 | - | UL 94 |
| Thickness tested | 1.7 | mm | - |
| DTUL @ 264 psi | 120 | °C | ASTM D 648 |

| Other properties | Value | Unit | Test Standard |
|------------------|-------|-------------------|---------------|
| Density | 1350 | kg/m ³ | ASTM D 792 |

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|-------------|------|---------------|
| Pre-drying - Temperature | 75 - 85 | °C | - |
| Pre-drying - Time | 3 - 5 | h | - |
| Processing humidity | ≤0.02 | % | - |
| Melt temperature | 235 - 265 | °C | - |
| Mold temperature | 50 - 80 | °C | - |
| Zone 1 | 220 - 240 | °C | - |
| Zone 2 | 235 - 255 | °C | - |
| Zone 3 | 250 - 265 | °C | - |
| Nozzle temperature | 250 - 265 | °C | - |
| Screw speed | 40 - 70 | rpm | - |
| Back pressure | 0.02 - 0.06 | MPa | - |

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant

Applications

Electrical and Electronical, General Purpose

Regional Availability

North America, Europe, Asia Pacific, South and Central America