LUPOY GP1006FL

PC LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	**22**	g/10min	ASTM D 1238
Temperature	**300**	°C	-
Load	**1.2**	kg	-
Mold Shrinkage, MD	**0.006**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	**61.8**	MPa	ASTM D 638
Elongation at Break	**150**	%	ASTM D 638
Flexural Modulus	**2256**	MPa	ASTM D 790
Flexural Strength	**103**	MPa	ASTM D 790
Rockwell Hardness	**R 118**	-	ASTM D 785
Izod Impact notched, 1/8 in	**660**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ISO Data			
Burning behav. 5V at thickness h	**5VA**	class	IEC 60695-11-20
Thickness tested	**2.5**	mm	-
ASTM Data			
UL 94 Flame rating	**V-0**	-	UL 94
Thickness tested	**1**	mm	-
DTUL @ 264 psi	**130**	°C	ASTM D 648
Vicat Temperature	**141**	°C	ASTM D 1525

Other properties	Value	Unit	Test Standard
Density	**1210**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**100 - 120**	°C	-
Pre-drying - Time	**3 - 5**	h	-
Processing humidity	**≤0.02**	%	-
Melt temperature	**300 - 320**	°C	-
Mold temperature	**80 - 120**	°C	-
Zone 1	**260 - 280**	°C	-
Zone 2	**280 - 300**	°C	-
Zone 3	**300 - 320**	°C	-
Nozzle temperature	**300 - 320**	°C	-
Screw speed	**40 - 70**	rpm	-
Back pressure	**1 - 4**	MPa	-

Characteristics

Processing

Injection Molding

Applications

IT / Business Machine, Electrical and Electronical

Special Characteristics

Flame retardant

Regional Availability

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