

General Information
Product Description

 Description
 Halogen Free Flame Retardant, Chemical Resistance, High Impact at Low Temperature

 Applications
 IT/OA Housing and Components

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • Latin America • North America
Additive	• Flame Retardant
Features	• Chemical Resistant • Flame Retardant • Halogen Free • High Impact Resistance
Uses	• Housings
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield, 3.20 mm)	54.9	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2160	MPa	ASTM D790
Flexural Strength ³ (3.20 mm)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	290	J/m	
23°C, 3.20 mm	690	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm	129	°C	
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.5 mm)	V-0		UL 94

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Lupoy® GN1004FA

LG Chem Ltd. - Polycarbonate

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	100 to 110	°C
Drying Time	3.0 to 5.0	hr
Rear Temperature	275 to 290	°C
Middle Temperature	285 to 305	°C
Front Temperature	290 to 310	°C
Nozzle Temperature	285 to 305	°C
Processing (Melt) Temp	290 to 310	°C
Mold Temperature	80 to 110	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm

Injection Notes

Minimum Moisture Content: 0.02%

Notes

¹ Typical properties: these are not to be construed as specifications.

² 50 mm/min

³ 10 mm/min