

General Information
Product Description

Description

General Purpose, Transparency, Mold Release

Application

IT/OA, E&E Housing and Components, Automotive Interior

General

Material Status	• Commercial: Active		
Availability	• Asia Pacific	• Latin America	
	• Europe	• North America	
Additive	• Mold Release		
Features	• General Purpose	• Good Mold Release	
Uses	• Automotive Interior Parts	• Electrical Housing	• Electrical/Electronic Applications
Appearance	• Clear/Transparent		
Processing Method	• Injection Molding		

ASTM & ISO Properties¹

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)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C, 3.20 mm, Injection Molded)	0.50 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ²			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	61.8	MPa	
Tensile Elongation ²			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	150	%	
Flexural Modulus ³ (23°C, 3.20 mm, Injection Molded)	2260	MPa	ASTM D790
Flexural Strength ³ (23°C, 3.20 mm, Injection Molded)	98.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	740	J/m	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C, Injection Molded)	118		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	132	°C	
Vicat Softening Temperature	141	°C	ASTM D1525 ⁴
RTI Elec	130	°C	UL 746
RTI Imp	130	°C	UL 746
RTI Str	130	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	2.0E+17	ohms-cm	ASTM D257
Comparative Tracking Index	250	V	IEC 60112

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Lupoy® GP1000MR
LG Chem Ltd. - Polycarbonate

Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm		HB	
3.2 mm		HB	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	100 to 120	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	260 to 280	°C
Middle Temperature	280 to 300	°C
Front Temperature	300 to 320	°C
Nozzle Temperature	300 to 320	°C
Processing (Melt) Temp	300 to 320	°C
Mold Temperature	80 to 120	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm

Notes

- ¹ Typical properties: these are not to be construed as specifications.
- ² 50 mm/min
- ³ 10 mm/min
- ⁴ Rate A (50°C/h), Loading 2 (50 N)