

**General Information**
**Product Description**

Description

General Purpose, Transparency

Application

Keypad for Mobile Phone, Automotive (Interior)

**General**

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

**ASTM & ISO Properties <sup>1</sup>**

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.20	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	13	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 <sup>2</sup>			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	60.8	MPa	
Tensile Elongation <sup>2</sup>			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	150	%	
Flexural Modulus <sup>3</sup> (23°C, 3.20 mm, Injection Molded)	2260	MPa	ASTM D790
Flexural Strength <sup>2</sup> (23°C, 3.20 mm, Injection Molded)	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	750	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 <sup>4</sup>
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® GP1000SW**  
**LG Chem Ltd. - Polycarbonate**

<b>Flammability</b>	<b>Nominal Value</b>	<b>Unit</b>	<b>Test Method</b>
Flame Rating			UL 94
1.5 mm		HB	
3.2 mm		HB	

**Processing Information**

<b>Injection</b>	<b>Nominal Value</b>	<b>Unit</b>
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**

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