

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

Description  
General Purpose, Heat Resistance

Application  
IT/OA, E&E Housing and Components, Automotive (Interior)

**General**

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • Latin America • North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight
Features	• General Purpose • Good Heat Resistance
Uses	• Automotive Interior Parts • Electrical Housing • Electrical/Electronic Applications
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.25	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)	0.20 to 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup>			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	78.5	MPa	
Flexural Modulus <sup>3</sup> (23°C, 3.20 mm, Injection Molded)	3530	MPa	ASTM D790
Flexural Strength <sup>3</sup> (23°C, 3.20 mm, Injection Molded)	127	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	69	J/m	ASTM D256
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C, Injection Molded)	124		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	140	°C	
RTI Elec	80.0	°C	UL 746
RTI Imp	80.0	°C	UL 746
RTI Str	80.0	°C	UL 746

**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	270 to 300	°C
Middle Temperature	280 to 310	°C

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# Lupoy® GP2100

## LG Chem Ltd. - Polycarbonate

Injection	Nominal Value	Unit
Front Temperature	290 to 330	°C
Nozzle Temperature	290 to 330	°C
Processing (Melt) Temp	300 to 340	°C
Mold Temperature	90 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> 5.0 mm/min

<sup>3</sup> 1.3 mm/min