

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

Description  
General Purpose, High Impact, Chemical Resistance

Application  
Mobile Phone Housing

**General**

Material Status	• Commercial: Active		
Availability	• Asia Pacific • Europe	• Latin America • North America	
Features	• Chemical Resistant	• General Purpose	• High Impact Resistance
Uses	• Cell Phones	• Electrical Housing	
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 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup>			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	56.9	MPa	
Tensile Elongation <sup>2</sup>			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	100	%	
Flexural Modulus <sup>3</sup> (23°C, 3.20 mm, Injection Molded)	2060	MPa	ASTM D790
Flexural Strength <sup>3</sup> (23°C, 3.20 mm, Injection Molded)	93.2	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)	117		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	128	°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			UL 94
1.6 mm		HB	
3.0 mm		V-2	

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# Lupoy® HI1002ML

## LG Chem Ltd. - Polycarbonate

### Processing Information

Injection	Nominal Value	Unit
Drying Temperature	100 to 110	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	0.020	%
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

### 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