

**General Information**

General	
Material Status	• Commercial: Active
Availability	<ul style="list-style-type: none"> <li>• Asia Pacific</li> <li>• Europe</li> <li>• Latin America</li> <li>• North America</li> </ul>
Uses	<ul style="list-style-type: none"> <li>• Electrical Housing</li> <li>• Electrical/Electronic Applications</li> </ul>
Appearance	• Clear/Transparent
Processing Method	• Injection Molding

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

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.21	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	32	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>2</sup> (Yield, 3.20 mm)	72.6	MPa	ASTM D638
Tensile Elongation <sup>2</sup> (Break, 3.20 mm)	> 50	%	ASTM D638
Flexural Modulus <sup>3</sup> (3.20 mm)	2650	MPa	ASTM D790
Flexural Strength <sup>3</sup> (3.20 mm)	118	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	42	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load 0.45 MPa, Unannealed, 6.40 mm	105	°C	ASTM D648
RTI Elec	130	°C	UL 746
RTI Imp	130	°C	UL 746
RTI Str	130	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.5 mm	HB		
3.0 mm	HB		
Optical	Nominal Value	Unit	Test Method
Transmittance	89.0	%	ASTM D1003

**Processing Information**

Injection	Nominal Value	Unit
Drying Temperature	75 to 85	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	220 to 240	°C
Middle Temperature	235 to 255	°C
Front Temperature	250 to 265	°C
Nozzle Temperature	250 to 265	°C

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# Lupoy® GP1000LG

## LG Chem Ltd. - Polycarbonate

Injection	Nominal Value	Unit
Processing (Melt) Temp	235 to 265	°C
Mold Temperature	50 to 80	°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