

LUPOY GN3101EF

Extrusion Molding, PC MF Reinforced

Description

Halogen Free Flame Retardance
EN45545-2 Compliant. (R22/R23,HL3)

Application

Automotive(interior), E&E(housing)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.34
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.2~0.4
Melt Flow Rate	260℃, 5.0kg	ASTM D1238	g/10min	9.5
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50 mm/min		kg/cm ²	560
Flexural Strength, 3.2mm	10 mm/min	ASTM D790	kg/cm ²	1,020
Flexural Modulus, 3.2mm	10 mm/min	ASTM D790	kg/cm ²	38,000
IZOD Impact Strength, 3.2mm (Notched)	23℃ -30℃	ASTM D256	kg·cm/cm kg·cm/cm	8
Rockwell Hardness	R-Scale	ASTM D785	-	
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	℃ ℃	97
Vicat Softening Temperature	5kg, 50℃/h	ASTM D1525	℃	
Flammability		UL94		
0.75mm			class	V0
1.5mm			class	V0
3.0mm			class	
Relative Temperature Index		UL 746B		
Electrical			℃	80
Mechanical with Impact			℃	80
Mechanical without Impact			℃	80

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23℃, 50% relative humidity.

Updated : Feb. 24. 2020

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Electrical

Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts
Surface Resistivity		IEC 60093	Ohm
Volume Resistivity	23°C	ASTM D257	Ohm·m
Arc Resistance	23°C	ASTM D495	Ohm·cm
Dielectric Strength, 1mm	23°C	ASTM D149	kV/mm
Dielectric Constant (10 ⁶ Hz)	23°C	ASTM D150	sec

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Processing Guide (Extrusion Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 90
Drying Time		hrs	4 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		°C	235 ~ 260
Cylinder Temperature	Rear	°C	225 ~ 240
	Middle	°C	235 ~ 245
	Front	°C	245 ~ 260
Nozzle Temperature		°C	230 ~ 260
Mold Temperature		°C	Depend on thickness

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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