SolutionPartner

LG Chem

LUMILOY GP1000D

Injection Molding Grade, General Purpose

Description

High Impact Strength

Application

Electric and Electronic parts

Properties	Test Condition	Test Method	Unit	GP1000D
Physical				
Specific Gravity		ASTM D792	-	1.06
Melt Flow Rate	280℃/5kg	ASTM D1238	g/10min	7.5
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm^2	590
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	50mm/min		%	40
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm^2	980
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm^2	23,300
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	22.0
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	134
(Unannealed)	4.6kg		℃	
Heat Deflection Temperature, 3.2mm		ASTM D648		
(Unannealed)	18.6kg		℃	128
(Unannealed)	4.6kg		℃	

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 humidt

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	90 ~ 100
Drying Time		hrs	4 ~ 5
Minimum Moisture Content		%	0.03
Melt Temperature		℃	280 ~ 320
Cylinder Temperature	Rear	℃	260 ~ 300
	Middle	℃	270 ~ 310
	Front	℃	270 ~ 310
Nozzle Temperature		℃	270 ~ 310
Mold Temperature		℃	70 ~ 110