SolutionPartner

LG Chem

LUMILOY GP1000D

Injection Molding Grade, General Purpose

Eq. Noryl 731 S

Description

High Flow, High Impact Strength

Application

Electric and Electronic parts

Properties	Test Condition	Test Method	Unit	Typical Property
Physical				
Specific Gravity		ASTM D792	-	1.04
Melt Flow Rate	280℃/5kg	ASTM D1238	g/10min	25
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm^2	500
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	50
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm^2	900
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm^2	25,000
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg·cm/cm	16.0
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	124

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 humic

Updated : 2014-08-01

SolutionPartner

LG Chem

LUMILOY GP1000D

Injection Molding Grade, General Purpose

Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	80 ~ 90
Drying Time		hrs	4 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		℃	270 ~ 310
Cylinder Temperature	Rear	℃	260 ~ 300
	Middle	℃	270 ~ 310
	Front	℃	270 ~ 310
Nozzle Temperature		℃	270 ~ 310
Mold Temperature		℃	70 ~ 110