



LUPOY ER1000D

Injection Molding PC

Description

PCR(Post-Consumer Recycled Material) 50%
Transparent

Application

General Purpose

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.2
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5 ~ 0.8
Melt Flow Rate	300 °C/1.2kg	ASTM D1238	g/10min	11
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	620
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	90
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	980
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	22,000
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	kgf.cm/cm	75
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	132

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 moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : Fwb, 2022

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100 ~ 120
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		℃	300 ~ 320
Cylinder Temperature	Rear	℃	260 ~ 290
	Middle	℃	280 ~ 310
	Front	℃	300 ~ 320
Nozzle Temperature		℃	300 ~ 320
Mold Temperature		℃	80 ~ 120
Back Pressure		kg/cm ²	
Screw Speed		rpm	40 ~ 70

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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