



LUPOY ER1004A

Injection Molding PC

Description

PCR(Post-Consumer Recycled Material) 30%
High Impact at Low Temperature

Application

General Purpose
Mobile Phone Housing
Mobile Phone Case

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.2
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5 ~ 0.7
Melt Flow Rate	300 °C/1.2kg	ASTM D1238	g/10min	10
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	570
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	100
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	850
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	20,000
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	kg·cm/cm	65
	-30°C		kg·cm/cm	45
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	127
Flammability		UL94		
1.5mm			class	HB
3.0mm			class	HB

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 molded 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		°C	100 ~ 110
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		°C	290 ~ 310
Cylinder Temperature	Rear	°C	275 ~ 290
	Middle	°C	285 ~ 305
	Front	°C	290 ~ 310
Nozzle Temperature		°C	285 ~ 305
Mold Temperature		°C	80 ~ 110
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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