



LUPOY ER2253F

Injection Molding, PC + GF25%

Description

PCR(Post Consumer Recycled) 30%
Halogen Free Flame Retardant
High Stiffness

Application

IT/OA Housing and Components
Laptop Cover, Tablet Bezel

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.39
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.3
Melt Flow Rate	260°C/5kg	ASTM D1238	g/10min	24
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm ²	1,150
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	1,700
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	75,000
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	kg·cm/cm	9
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	90
Flammability		UL94		
0.8mm			class	V-0
1.0mm			class	V-0
3.0mm			class	V-0
Relative Temperature Index (RTI)		UL 746B		
Electrical			°C	80
Mechanical with Impact			°C	80
Mechanical without Impact			°C	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 moulded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Updated : Feb, 2022

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	85 ~ 90
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.04
Melt Temperature		°C	270 ~ 320
Cylinder Temperature	Rear	°C	260 ~ 290
	Middle	°C	270 ~ 310
	Front	°C	280 ~ 320
Nozzle Temperature		°C	280 ~ 320
Mold Temperature		°C	60 ~ 100
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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