



LUPOY ER5006N

Injection Molding PC/ABS

Description

PCR(Post-Consumer Recycled Material) 50%
Low Temperature Ductility
Medium PC Contents

Application

General Purpose
Automotive Interior/Exterior
I/P., Garnish, Trim, AVN, Spoiler

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ISO 1183	g/cm ³	1.13
Molding Shrinkage		ISO 294-4	%	0.5~0.8
Melt Flow Rate	260℃ / 5kg	ISO 1133	g/10min	23
Mechanical				
Tensile Strength @ Yield	50mm/min	ISO 527	Mpa	51
Tensile Elongation @ Break	50mm/min	ISO 527	%	93
Tensile Modulus	1mm/min	ISO 527	Mpa	2,700
Flexural Strength	2mm/min	ISO 178	Mpa	83
Flexural Modulus	2mm/min	ISO 178	Mpa	2,260
Charpy Impact Strength (Notched)	23℃ -30℃	ISO 180/1A	KJ/m ² KJ/m ²	48 35
Thermal				
Heat Deflection Temperature (Unannealed, Flatwise)	1.8Mpa	ISO 75	℃	99
Heat Deflection Temperature (annealed, Flatwise)	1.8MPa	ISO 75	℃	112
Vicat Softening Temperature	5daN, 50℃/h	ISO 306	℃	121

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℃, 50% relative humidity.

Updated : Sep, 2021

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 100
Drying Time		hrs	4 ~ 6
Maximum Moisture Content		%	0.02
Melt Temperature		°C	240 ~ 270
Cylinder Temperature	Rear	°C	240 ~ 270
	Middle	°C	245 ~ 275
	Front	°C	245 ~ 275
Nozzle Temperature		°C	245 ~ 275
Mold Temperature		°C	50 ~ 70
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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