



LUPOY ER5100N

Injection Molding PC/ABS + GF10%

Description

PCR(Post-Consumer Recycled Material) 50%
High Stiffness

Application

General Purpose
Automotive Interior
Trim, Panel, Arm Rest

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ISO 1183	g/cm ³	1.22
Molding Shrinkage		ISO 294-4	%	0.3 ~ 0.4
Melt Flow Rate	260°C / 5kg	ISO 1133	g/10min	18
Mechanical				
Tensile Strength		ISO 527		
@ Yield	5mm/min		Mpa	78
Tensile Elongation		ISO 527		
@ Break	5mm/min		%	4
Tensile Modulus	1mm/min	ISO 527	Mpa	5,200
Flexural Strength	2mm/min	ISO 178	Mpa	124
Flexural Modulus	2mm/min	ISO 178	Mpa	4,050
Charpy Impact Strength		ISO 180/1A		
(Notched)	23°C		KJ/m ²	12
	-30°C		KJ/m ²	9
Thermal				
Heat Deflection Temperature		ISO 75		
(Unannealed, Flatwise)	1.8Mpa		°C	123
Vicat Softening Temperature	5daN, 50°C/h	ISO 306	°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 : Sep, 2021

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.



LUPOY ER5100N

Injection Molding PC/ABS + GF10%

Description

PCR(Post-Consumer Recycled Material) 50%
High Stiffness

Application

General Purpose
Automotive Interior
Trim, Panel, Arm Rest

Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	85 ~ 100
Drying Time		hrs	4 ~ 6
Maximum Moisture Content		%	0.02
Melt Temperature		°C	235 ~ 265
Cylinder Temperature	Rear	°C	220 ~ 240
	Middle	°C	235 ~ 255
	Front	°C	245 ~ 275
Nozzle Temperature		°C	250 ~ 265
Mold Temperature		°C	50 ~ 80
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.

Updated : Sep, 2021

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.