



LUPOY ER5300A

Injection Molding PC/ABS + GF30%

Description

PCR(Post-Consumer Recycled Material) 30%
High Stiffness

Application

General Purpose
Automotive Interior
Trim

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ISO 1183	g/cm ³	1.34
Molding Shrinkage		ISO 294-4	%	0.1 ~ 0.3
Melt Flow Rate	260°C / 5kg	ISO 1133	g/10min	10
Mechanical				
Tensile Strength		ISO 527		
@ Yield	5mm/min		Mpa	120
Tensile Elongation		ISO 527		
@ Break	5mm/min		%	1.4
Flexural Strength	2mm/min	ISO 178	Mpa	165
Flexural Modulus	2mm/min	ISO 178	Mpa	7,300
Charpy Impact Strength		ISO 180/1A		
(Notched)	23°C		KJ/m ²	10
	-30°C		KJ/m ²	8
Thermal				
Heat Deflection Temperature		ISO 75		
(Unannealed, Flatwise)	1.8Mpa		°C	115
Vicat Softening Temperature	5daN, 50°C/h	ISO 306	°C	120

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.

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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.



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