

SolutionPartner


LUPOY EU5000W

Injection Molding, PC/ASA

Description

Weathering Resistance, Good Flow

Application

Automotive Exterior

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.13
Molding Shrinkage		ASTM D955	%	
Melt Flow Rate	260 °C/5kg	ASTM D1238	g/10min	42
Water Absorption	23 °C, 24hrs	ASTM D570	%	
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	507
Tensile Elongation, 3.2mm @ Yield	50mm/min	ASTM D638	%	-
@ Break	50mm/min		%	50.0
Flexural Strength, 6.4mm	10mm/min	ASTM D790	kg/cm ²	782
Flexural Modulus, 6.4mm	10mm/min	ASTM D790	kg/cm ²	21,000
IZOD Impact Strength, 6.4mm (Notched)	23 °C -30 °C	ASTM D256	kg·cm/cm kg·cm/cm	12 6
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C °C	106
Flammability		UL94	class	
0.71mm			class	
1.5mm			class	
3.3mm			class	
Relative Temperature Index		UL 746B		
Electrical			°C	
Mechanical with Impact			°C	
Mechanical without Impact			°C	
Electrical				
Comparative Tracking Index(CTI)	Solution A	UL 746	PLC	
Volume Resistivity	23 °C	ASTM D257	Ohm·cm	
Arc Resistance	23 °C	ASTM D495	PLC	
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	

Note) All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 9-Mar-15

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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	5~15
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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