

# LUPOY ER1006FH

Injection Molding, PC

## Description

Halogen Free Flame Retardant, High Heat Resistance  
20% PCR(Post Consumer Recycled) material

## Application

IT/OA Housing and Components (Adaptor)

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.2
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5~0.7
Melt Flow Rate	300°C/1.2kg	ASTM D1238	g/10min	11
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm <sup>2</sup>	630
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	50mm/min		%	80
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm <sup>2</sup>	940
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm <sup>2</sup>	21,000
IZOD Impact Strength, 3.2mm (Notched)	23°C -30°C	ASTM D256	kg·cm/cm kg·cm/cm	65
Rockwell Hardness	R-Scale	ASTM D785	-	118
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C °C	128
Vicat Softening Temperature	5kg, 50°C/h	ASTM D1525	°C	137
Flammability		UL94		
1.0mm			class	V-0
1.5mm			class	V-0
1.7mm			class	V-0, 5VB
2.5mm			class	V-0, 5VA
Relative Temperature Index (RTI)		UL 746B		
Electrical			°C	120
Mechanical with Impact			°C	115
Mechanical without Impact			°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 moulded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Updated : Mar-18, 2017

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## Electrical

Comparative Tracking Index(CTI)		UL746	PLC code	3
Surface Resistivity		IEC 60093	Ohm	-
Volume Resistivity	23℃	ASTM D257	Ohm·m	>1.0E+16
Arc Resistance	23℃	ASTM D495	PLC code	6
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm	-
Dielectric Constant (10 <sup>9</sup> Hz)	23℃	ASTM D150	-	2.96

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## Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100 ~ 120
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		℃	300 ~ 320
Cylinder Temperature	Rear	℃	260 ~ 280
	Middle	℃	280 ~ 300
	Front	℃	300 ~ 320
Nozzle Temperature		℃	300 ~ 320
Mold Temperature		℃	80 ~ 120
Back Pressure		kg/cm <sup>2</sup>	-
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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