SolutionPartner

LG Chem

# LUPOY HR5006A

**Injection Molding, ABS+PC Resin**

## Description

low temperature impact resistance Rohs compliant

## Application

IT/OA, Electric & Electronic Housing and Auto

| Properties | Test Condition | Test Method | Unit | Typical Value |
|---|---|---|---|---|
| **Physical** | | | | |
| Specific Gravity | | ASTM D792 | - | 1.13 |
| Molding Shrinkage (Flow), 3.2mm | | ASTM D955 | % | 0.5~0.8 |
| Melt Flow Rate | 250℃/2.16kg | ASTM D1238 | g/10min | 4 |
| **Mechanical** | | | | |
| Tensile Strength, 3.2mm | | ASTM D638 | | |
| @ Yield | 5mm/min | | $kg/cm^2$ | 550 |
| Tensile Elongation, 3.2mm | | ASTM D638 | | |
| @ Yield | 5mm/min | | % | |
| @ Break | 5mm/min | | % | 100 |
| Tensile Modulus, 3.2mm | | ASTM D638 | $kg/cm^2$ | |
| Flexural Strength, 3.2mm | 1.3mm/min | ASTM D790 | $kg/cm^2$ | 800 |
| Flexural Modulus, 3.2mm | 1.3mm/min | ASTM D790 | $kg/cm^2$ | 20,000 |
| IZOD Impact Strength, 3.2mm | | ASTM D256 | | |
| (Notched) | 23℃ | | kg·cm/cm | 65 |
| | -30℃ | | kg·cm/cm | 50 |
| Rockwell Hardness | R-Scale | ASTM D785 | - | |
| **Thermal** | | | | |
| Heat Deflection Temperature, 6.4mm | | ASTM D648 | | |
| (Unannealed) | 18.6kg | | ℃ | 108 |
| | 4.6kg | | ℃ | |
| Vicat Softening Temperature | | ASTM D1525 | | |
| | 5kg, 50℃/h | | ℃ | |
| Ball Pressure Temperature | | IEC 60695-10-2 | ℃ | |
| Burning Rate, 3.2mm | | FMVSS 302 | mm | |
| Flammability | | UL94 | | |
| 0.7mm | | | class | |
| 1.6mm | | | class | HB |
| 2.5mm | | | class | |
| 3.0mm | | | class | |
| Relative Temperature Index | | UL 746B | | |
| Electrical | | | ℃ | |
| Mechanical with Impact | | | ℃ | |
| Mechanical without Impact | | | ℃ | |

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 molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : Mar-31,2012

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## Electrical

| | | | |
|---|---|---|---|
| Comparative Tracking Index(CTI) | Solution A | IEC 60112 | Volts |
| Surface Resistivity | | IEC 60093 | Ohm |
| Volume Resistivity | 23℃ | ASTM D257 | Ohm·m |
| Arc Resistance | 23℃ | ASTM D495 | Ohm·cm |
| Dielectric Strength, 1mm | 23℃ | ASTM D149 | kV/mm |
| Dielectric Constant ($10^6$ Hz) | 23℃ | ASTM D150 | sec |

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## *Processing Guide (Extrusion Molding)*

| Processing Parameters | | Unit | Value |
|---|---|---|---|
| Drying Temperature | | ℃ | 80~100 |
| Drying Time | | hrs | 4~6 |
| Minimum Moisture Content | | % | 0.02 |
| Melt Temperature | | ℃ | 250~270 |
| Barrel Temperature | Rear | ℃ | 240~270 |
| | Middle | ℃ | 245~275 |
| | Front | ℃ | 245~275 |
| Die Temperature | | ℃ | 245~275 |
| Mold Temperature | | ℃ | 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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