

LUPOY ER2102

Injection Molding, PC+GF10%

Description

General Purpose, Good Toughness, Chemical Resistance
PCR material 30%

Application

Moible Phone Housing

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.25
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.2 ~ 0.4
Melt Flow Rate	300°C/1.2kg	ASTM D1238	g/10min	8
Mechanical				
Tensile Strength, 3.2mm @ Yield	5mm/min	ASTM D638	kg/cm ²	540
Tensile Elongation, 3.2mm @ Break	5mm/min	ASTM D638	%	20
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	kg/cm ²	
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	960
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	31,000
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	kg·cm/cm	28
	-30°C		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	136
	4.6kg		°C	
Vicat Softening Temperature	5kg, 50°C/h	ASTM D1525	°C	143
Flammability 0.75mm		UL94	class	HB
Relative Temperature Index		UL 746B		
Electrical			°C	80
Mechanical with Impact			°C	80
Mechanical without Impact			°C	80

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°C, 50% relative humidity.

Updated : Jul-02, 2020

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Electrical

Property	Condition	Standard	Unit
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts
Surface Resistivity		IEC 60093	Ohm
Volume Resistivity	23°C	ASTM D257	Ohm·m
Arc Resistance	23°C	ASTM D495	Ohm·cm
Dielectric Strength, 1mm	23°C	ASTM D149	kV/mm
Dielectric Constant (10 ⁶ Hz)	23°C	ASTM D150	sec

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	100 ~ 120
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		°C	295 ~ 310
Cylinder Temperature	Rear	°C	280 ~ 295
	Middle	°C	285 ~ 300
	Front	°C	290 ~ 305
Nozzle Temperature		°C	290 ~ 305
Mold Temperature		°C	90 ~ 110
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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