

# LUPOY ER2303F

(Tentative)

Injection Molding Grade, PC+Glass Fiber Reinforced

## Description

PCR 30%, Halogen Free Flame Retardant, High Stiffness

## Application

IT/OA(Notebook PC Housing)

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.43
Melt Flow Rate	300 °C/2.16kg	ASTM D1238	g/10min	26
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	5mm/min		kg/cm <sup>2</sup>	1,300
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm <sup>2</sup>	1,800
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm <sup>2</sup>	82,000
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	10
	-30 °C		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	120
<b>Thermal</b>				
Flammability 0.8mm		UL94	class	V-0
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 moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : Mar,15-2020

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## Electrical

Property	Solution A	IEC 60112	Volts
Comparative Tracking Index(CTI)			
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 <sup>6</sup> Hz)	23 °C	ASTM D150	sec

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## Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	85 ~ 90
Drying Time		hrs	4 ~ 6
Maximum Moisture Content		%	0.02
Melt Temperature		°C	270 ~ 320
Cylinder Temperature	Rear	°C	270 ~ 290
	Middle	°C	280 ~ 310
	Front	°C	290 ~ 320
Nozzle Temperature		°C	290 ~ 320
Mold Temperature		°C	60 ~ 100
Back Pressure		kg/cm <sup>2</sup>	10 ~ 20
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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