

LUPOY EC5000A

Injection Molding, PC/ABS

Description

General Purpose, Anti-Static.

Application

E&E(Housing)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.18
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.6
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	9
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	500
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	
@ Break	50mm/min		%	60
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	840
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	22,000
IZOD Impact Strength, 3.2mm (Notched)	23 °C -30 °C	ASTM D256	kg·cm/cm kg·cm/cm	50
Rockwell Hardness	R-Scale	ASTM D785	-	
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C °C	97
Vicat Softening Temperature	5kg, 50 °C/h	ASTM D1525	°C	
Ball Pressure Temperature		IEC 60695-10-2	°C	
Burning Rate, 3.2mm		FMVSS 302	mm	
Flammability		UL94		
0.8mm			class	
1.5mm			class	HB
2.0mm			class	
3.0mm			class	
Relative Temperature Index		UL 746B		
Electrical			°C	60
Mechanical with Impact			°C	60
Mechanical without Impact			°C	60

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 molded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : Apr-06, 2016

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Electrical

Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	
Surface Resistivity		IEC 60093	Ohm	$10^{10} \sim 10^{11}$
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 (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	60~80
Drying Time		hrs	4~6
Maximum Moisture Content		%	0.02
Melt Temperature		℃	230 ~ 260
Cylinder Temperature	Rear	℃	210 ~ 240
	Middle	℃	215 ~ 250
	Front	℃	225 ~ 260
Nozzle Temperature		℃	220 ~ 250
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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