

LUPOY HR5007AT

Injection Molding Grade, PC/ABS
Description

Good surface quality, Heat resistance

Application

Automotive bezel, Rear combi

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.15
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5~0.8
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	5.3
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	560
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	>100
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	880
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	23,000
IZOD Impact Strength, 3.2mm (Notched)	23 °C -30 °C	ASTM D256	kg·cm/cm	52 23
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C	114 128
Flammability 1.6mm 3.0mm		UL94	class	HB HB
Relative Temperature Index Electrical Mechanical with Impact Mechanical without Impact		UL 746B	°C	60 60 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 molulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80~100
Drying Time	hrs	4~6
Minimum Moisture Content	%	0.02
Melt Temperature	°C	240 ~ 270
Cylinder Temperature	Rear	240 ~ 270
	Middle	245 ~ 275
	Front	245 ~ 275
Nozzle Temperature	°C	245 ~ 275
Mold Temperature	°C	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.