

LUPOY MP5000AM

Injection Molding, PC/ABS

Description

General Purpose, Metal Plating

Application

Automotive(Outerior), E&E(Housing)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.1
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5~0.8
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	5.5
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	470
Tensile Elongation, 3.2mm @ Yield	50mm/min	ASTM D638	%	
@ Break	50mm/min		%	>100
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	730
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	19,500
IZOD Impact Strength, 3.2mm (Notched)	23 °C -30 °C	ASTM D256	kg·cm/cm	50
			kg·cm/cm	
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C	98
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	0.8mm 1.5mm 2.5mm 3.0mm	UL94	class	HB
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 moludled specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : Aug-01, 2014

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Electrical

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	80~90
Drying Time	hrs	4~6
Maximum Moisture Content	%	0.02
Melt Temperature	°C	240 ~ 265
Cylinder Temperature	Rear	235 ~ 260
	Middle	235 ~ 265
	Front	235 ~ 265
Nozzle Temperature	°C	235 ~ 265
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.

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