

LUPOY HP5004A

(PC+ABS)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	4	g/10min	ASTM D 1238
Temperature	250	°C	-
Load	2.16	kg	-
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	58.9	MPa	ASTM D 638
Elongation at Break	130	%	ASTM D 638
Flexural Modulus	2060	MPa	ASTM D 790
Flexural Strength	88.3	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	613	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	471	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	0.7	mm	-
DTUL @ 264 psi	118	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Density	1140	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	3 - 5	h	-
Processing humidity	≤0.02	%	-
Melt temperature	255 - 285	°C	-
Mold temperature	80 - 100	°C	-
Zone 1	240 - 250	°C	-
Zone 2	250 - 280	°C	-
Zone 3	250 - 280	°C	-
Nozzle temperature	250 - 280	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	1 - 4	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Features

Weldable

Applications

Electrical and Electronical, General Purpose

Regional Availability

North America, Europe, Asia Pacific, South and Central America