

LUPOY HR5006A

(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	0.0065	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	53	MPa	ASTM D 638
Elongation at Break	110	%	ASTM D 638
Flexural Modulus	2207	MPa	ASTM D 790
Flexural Strength	83.4	MPa	ASTM D 790
Rockwell Hardness	R 113	-	ASTM D 785
Izod Impact notched, 1/8 in	589	J/m	ASTM D 256
Izod Impact notched, Low-Temperature	392	J/m	ASTM D 256
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	123^[1]	°C	ASTM D 648
DTUL @ 264 psi	108^[1]	°C	ASTM D 648
Vicat Temperature	122	°C	ASTM D 1525

1: 6.4 mm

Other properties	Value	Unit	Test Standard
Density	1130	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	4 - 6	h	-
Processing humidity	≤0.02	%	-
Melt temperature	240 - 270	°C	-
Mold temperature	50 - 70	°C	-
Zone 1	240 - 270	°C	-
Zone 2	245 - 275	°C	-
Zone 3	245 - 275	°C	-
Nozzle temperature	245 - 275	°C	-
Screw speed	40 - 70	rpm	-
Back pressure	0.5 - 1.5	MPa	-

Characteristics**Processing**

Injection Molding

Special Characteristics

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

Applications

Automotive, Electrical and Electronical

Regional Availability

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