

**LUPOY ER5006N**

(PC+ABS)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	23	g/10min	ISO 1133
Temperature	260	°C	-
Load	5	kg	-
Molding shrinkage, parallel	0.7	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2570	MPa	ISO 527
Yield stress	51	MPa	ISO 527
Strain at break	93	%	ISO 527
Flexural modulus, 23°C	2260	MPa	ISO 178
Flexural strength	83	MPa	ISO 178
Izod notched impact strength, +23°C	48	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	35	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	99	°C	ISO 75-1/-2
Vicat softening temperature, B	122	°C	ISO 306

Other properties	Value	Unit	Test Standard
Density	1130	kg/m <sup>3</sup>	ISO 1183

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 - 2	MPa	-

**Characteristics****Processing**

Injection Molding

**Special Characteristics**

High impact or impact modified

**Certifications**

Recycled Resin Content

**Applications**

Automotive

**Regional Availability**

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