

LUPOS SG5009-K1293

(PMMA+ASA)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	6.5	g/10min	ISO 1133
Temperature	220	°C	-
Load	10	kg	-
Molding shrinkage, parallel	0.6	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Yield stress	50	MPa	ISO 527
Strain at break	30	%	ISO 527
Flexural modulus, 23°C	2000	MPa	ISO 178
Flexural strength	70	MPa	ISO 178
Charpy notched impact strength, +23°C	4.5	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	2	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
ISO Data			
Temp. of deflection under load, 0.45 MPa	80	°C	ISO 75-1/-2
Vicat softening temperature, B	90	°C	ISO 306

Other properties	Value	Unit	Test Standard
Density	1150	kg/m ³	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	70 - 80	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.01	%	-
Melt temperature	220 - 230	°C	-
Mold temperature	40 - 60	°C	-
Zone 1	220 - 250	°C	-
Zone 2	220 - 250	°C	-
Zone 3	220 - 250	°C	-
Nozzle temperature	220 - 250	°C	-
Screw speed	70	rpm	-
Back pressure	1 - 4	MPa	-

Characteristics**Processing**

Injection Molding

Applications

Automotive

Special Characteristics

U.V. stabilized or stable to weather

Regional Availability

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

Features

High Gloss, Scratch Resistant