

# LUPOY HR5006A

Injection molding, PC/ABS

## Description

Heat Resistance, High Flow, High Impact

## Application

Automotive(Interior), E&E(Housing)

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.13
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5~0.8
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	4
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm <sup>2</sup>	540
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	50mm/min		%	110
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm <sup>2</sup>	850
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm <sup>2</sup>	22,500
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg-cm/cm	60
	-30 °C		kg-cm/cm	40
Rockwell Hardness	R-Scale	ASTM D785	-	113
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	108
	4.6kg		°C	123
Vicat Softening Temperature	5kg, 50 °C/h	ASTM D1525	°C	122
Flammability	1.5mm	UL94	class	
	3.2mm		class	
Relative Temperature Index		UL 746B		
Electrical			°C	
Mechanical with Impact			°C	
Mechanical without Impact			°C	

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 moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 13-Feb-20

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.

# LUPOY HR5006A

Injection molding, PC/ABS

## Description

Heat Resistance, High Flow, High Impact

## Application

Automotive(Interior), E&E(Housing)

### Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80~100	
Drying Time	hrs	4~6	
Maximum Moisture Content	%	0.02	
Melt Temperature	°C	240 ~ 270	
Cylinder Temperature	Rear	°C	240 ~ 270
	Middle	°C	245 ~ 275
	Front	°C	245 ~ 275
Nozzle Temperature	°C	245 ~ 275	
Mold Temperature	°C	50 ~ 70	
Back Pressure	kg/cm <sup>2</sup>	5~15	
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.

Updated : 13-Feb-20

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.