

Lupoy® NS5000

Polycarbonate + ABS

LG Chem Ltd.

Message:

Description
Heat Resistance, High Flow, High Impact.
Application
Automotive (Interior)

General Information			
Features	High Flow		
	High Impact Resistance		
	Medium Heat Resistance		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	5.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	56.9	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2260	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	86.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	540	J/m	
23°C, 3.20 mm	720	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	114	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 6.0	hr	
Minimum Moisture Content	0.020	%	
Rear Temperature	240 to 270	°C	
Middle Temperature	245 to 275	°C	
Front Temperature	245 to 275	°C	

Nozzle Temperature	245 to 275	°C
Processing (Melt) Temp	250 to 275	°C
Mold Temperature	50.0 to 70.0	°C
Screw Speed	40 to 70	rpm

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

