

Lupoy® HP5004A

Polycarbonate + ABS

LG Chem Ltd.

Message:

Description

General Purpose, Good Weld Properties, High Impact(at Low Temperature), Heat Resistance

Application

Mobile Phone Housing

General Information			
UL YellowCard	E67171-464734		
Features	General Purpose		
	Low Temperature Impact Resistance		
	Medium Heat Resistance		
	Weldable		
Uses	Cell Phones		
	Electrical Housing		
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)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.70	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	58.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	130	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2060	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	490	J/m	
23°C, 3.20 mm	640	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	118	°C	ASTM D648
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746

Flammability	Nominal Value	Test Method
Flame Rating (0.700 mm)	HB	UL 94

Injection	Nominal Value	Unit
Drying Temperature	80.0 to 100	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	240 to 250	°C
Middle Temperature	250 to 280	°C
Front Temperature	250 to 280	°C
Nozzle Temperature	250 to 280	°C
Processing (Melt) Temp	255 to 285	°C
Mold Temperature	80.0 to 100	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 70	rpm

NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	
5.	18.6kg	

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