

Lupox® TE5000D

Polycarbonate + PBT

LG Chem Ltd.

Message:

Description

Good surface

Application

Automotive(Lamp Housing)

General Information			
Features	Good Surface Finish		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.28	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	15	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.3 to 1.5	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.080	%	ASTM D570
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)	> 50	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2550	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	44	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm)	130	°C	ASTM D648
Peak Melting Temperature	223	°C	ASTM D3418
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	240 to 250	°C	
Middle Temperature	245 to 260	°C	
Front Temperature	250 to 260	°C	
Nozzle Temperature	250 to 260	°C	
Processing (Melt) Temp	240 to 250	°C	
NOTE			
1.	50 mm/min		
2.	50 mm/min		

3.	5.0 mm/min
4.	5.0 mm/min

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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

