

Lupoy® MP5000AM

Polycarbonate + ABS

LG Chem Ltd.

Message:

Description
General Purpose, Metal Plating
Application
Automotive(Outerior), E&E(Housing)

General Information			
Features	General Purpose		
Uses	Automotive Exterior Parts		
	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	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
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	46.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	1910	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	71.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	490	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	98.0	°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 (1.50 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 90.0	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	235 to 260	°C	
Middle Temperature	235 to 265	°C	
Front Temperature	235 to 265	°C	

Nozzle Temperature	235 to 265	°C
Processing (Melt) Temp	240 to 265	°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	
5.	18.6kg	

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