

Lupox® TE5011

Polycarbonate + PBT

LG Chem Ltd.

Message:

Description
High Impact, Dimensional Stability
Application
Automotive(Bumper Back Beam)

General Information			
Features	Good Dimensional Stability		
	High Impact Resistance		
Uses	Automotive Applications		
Forms	Pellets		
Processing Method	Injection Molding		
Multi-Point Data	Isothermal Stress vs. Strain (ISO 11403-1)		
	Secant Modulus vs. Strain (ISO 11403-1)		
	Specific Heat vs. Temperature (ISO 11403-2)		
	Viscosity vs. Shear Rate (ISO 11403-2)		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	17	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.70 to 1.0	%	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)	56.9	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2060	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	75.5	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	60	J/m	
0°C, 6.40 mm	30	J/m	
23°C, 3.20 mm	No Break		
23°C, 6.40 mm	65	J/m	

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	110	°C	
1.8 MPa, Unannealed, 6.40 mm	90.0	°C	

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	250 to 260	°C	
Middle Temperature	250 to 260	°C	
Front Temperature	255 to 265	°C	
Nozzle Temperature	260 to 270	°C	
Processing (Melt) Temp	260 to 270	°C	
Mold Temperature	60.0 to 80.0	°C	

NOTE

- | | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 2.5 mm/min |
| 4. | 2.5 mm/min |

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