

Lupox® LW5402A

Polycarbonate + PBT

LG Chem Ltd.

Message:

Description
Low Warpage, High Gloss
Application
E&E, Automotive(Bobbin, Switch)

General Information			
Features	High Gloss		
	Low Warpage		
Uses	Automotive Applications		
	Electrical/Electronic Applications		
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	1.60	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	12	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 0.60	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.060	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	108	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	6.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	6960	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	162	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	83	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	210	°C	
1.8 MPa, Unannealed, 6.40 mm	200	°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	240 to 255	°C
Middle Temperature	245 to 260	°C
Front Temperature	245 to 260	°C
Nozzle Temperature	245 to 260	°C
Processing (Melt) Temp	250 to 260	°C
Mold Temperature	60.0 to 100	°C

NOTE

- | | |
|----|------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 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

