

Lupox® TE5011M

Polycarbonate + PBT

LG Chem Ltd.

Message:

Description

High Impact, Dimensional Stability, Good Weatherability

Application

Automotive(Bumper Back Beam)

General Information			
Features	Good Dimensional Stability		
	Good Weather Resistance		
	High Impact Resistance		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/5.0 kg)	25	g/10 min	ASTM D1238
Molding Shrinkage - Flow	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)	47.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1860	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	68.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 6.40 mm	250	J/m	
23°C, 6.40 mm	590	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	95.0	°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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