

Lupoy® NS5000C

Polycarbonate + ABS

LG Chem Ltd.

Message:

Description

Heat Resistance, High Flow, High Impact.

Application

Automotive(Interior)

General Information			
UL YellowCard	E67171-101845986		
Features	Good Impact Resistance		
	High Flow		
	Medium Heat Resistance		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	4.8	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.50 to 0.80	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	53.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 100	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2160	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	85.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	540	J/m	
23°C, 3.20 mm	690	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	114	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 6.0	hr	
Minimum Moisture Content	0.020	%	
Rear Temperature	240 to 270	°C	
Middle Temperature	245 to 275	°C	

Front Temperature	245 to 275	°C
Nozzle Temperature	245 to 275	°C
Processing (Melt) Temp	250 to 275	°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

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