LUPOY HI5007UT

Injection Molding, PC/ABS, Non-flame Retardancy

Description

General Purpose , Low Gloss

Application

Auto / Exterior / e-Mobility

Properties	Condition	Method	Unit	Typical Value
Physical				
Specific Gravity	23℃	ISO 1183		1.13
Shrinkage		ISO 294-4		
Flow	2.0mm		%	0.6~0.8
Cross-flow	2.0mm		%	0.6~0.8
Melt Flow Rate	260℃, 5kg	ISO 1133	g/10min	12
Water Absorption	23°C, 50% RH	ISO 62	%	0.20
Mechanical				
Tensile Strength		ISO 527		
@Yield	4.0mm, 50mm/min		MPa	53
@Break	4.0mm, 50mm/min		MPa	48
Tensile Elongation		ISO 527		
@Yield	4.0mm, 50mm/min		%	4.9
@Break	4.0mm, 50mm/min		%	110
Tensile Modulus	4.0mm, 1mm/min	ISO 527	MPa	2,220
Flexural Strength	4.0mm, 2.0mm/min	ISO 178	MPa	82
Flexural Modulus	4.0mm, 2.0mm/min	ISO 178	MPa	2,200
IZOD Impact Strength		ISO 180		
4.0mm, Notched	23℃		kJ/m²	63
	-30℃		kJ/m²	26
	-40℃		kJ/m²	20
Charpy Impact Strength		ISO 179		
4.0mm, Notched	23℃		kJ/m²	64
	-30℃		kJ/m²	29
	-40℃		kJ/m²	23
Rockwell Hardness	R-Scale	ISO 2039		116
Shore Hardness		ISO 48-4		
Shore D	15s			
Thermal				
Melt Temperature	Peak	ISO 11357-3	℃	
Heat Deflection Temperature		ISO 75		
0.45MPa	4.0mm, Flatwise Unannealed		℃	124
1.8MPa	4.0mm, Flatwise Unannealed		℃	101
Vicat Softening Temperature	50N, 50℃/hr	ISO 306	℃	122
Coefficient of Linear Thermal Expansion		ISO 11359		
Flow	-30℃ ~ 80℃		10^{-6}m/m·℃	71
Cross-flow	-30℃ ~ 80℃		10^{-6}m/m·℃	80
Thermal Conductivity		ASTM E1461		
In-plane			W/m·K	

Through-plane		W/m·K

Flammability

Flammability	UL94	mm, Class

Electrical

Comparative Tracking Index(CTI)	Solution A	UL746A	PLC	
Surface Resistivity	23℃	IEC60093	Ohm	1E+15
Volume Resistivity	23℃	IEC60093	Ohm·m	1E+15
Dielectric Constant	23°C	ASTM D150		2.8
Dielectric Strength	23℃, 2.0mm	ASTM D149	kV/mm	23
EMI Shield	1GHz, 3.0mm	ASTM D4935	dB	

Note) Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.
Values given should not be interpreted as specification and not be used for designing part or tool.
All properties, except melt flow rate are measured by injection molded specimens after 48 hours storage at 23℃, 50% relative humidity.

Issued Date : 2023-05-24

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Processing Conditions (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	80~100
Drying Time		hrs	4~6
Maximum Moisture Content		%	0.02
Melt Temperature		℃	240~270
Cylinder Temperature	Rear	℃	240~270
	Middle	℃	250~280
	Front	℃	250~280
Nozzle Temperature		℃	250~280
Mold Temperature		℃	60~80

Note) These guides may not apply directly or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding and so on.