

LUPOY MP5000AM

Injection Molding Grade, PC/ABS

Description

General Purpose, Metal Plating

Application

Automotive, E&E(Housing)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.1
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5~0.8
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	4.5
Mechanical				
Tensile Strength, 3.2mm @ Yield	50mm/min	ASTM D638	kg/cm ²	470
Tensile Elongation, 3.2mm @ Yield	50mm/min	ASTM D638	%	
Tensile Elongation, 3.2mm @ Break	50mm/min	ASTM D638	%	100
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm ²	730
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm ²	20,500
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	48
	-30 °C		kg·cm/cm	25

Thermal

Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	102
	4.6kg		°C	

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 2017-03-03

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80~100
Drying Time	hrs	4~6
Maximum Moisture Content	%	0.03
Melt Temperature	°C	240 ~ 260
Cylinder Temperature	Rear	230 ~ 260
	Middle	240 ~ 280
	Front	240 ~ 280
Nozzle Temperature	°C	240 ~ 280
Mold Temperature	°C	60 ~ 90
Back Pressure	kg/cm ²	10~40
Screw Speed	rpm	40 ~ 70

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

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

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