

General Information
Product Description

 Description
 Flame Retardance, Anti-Static.

 Application
 E&E(Housing)

General

Material Status	• Commercial: Active
Availability	• Asia Pacific • Europe • Latin America • North America
Features	• Antistatic • Flame Retardant
Uses	• Electrical/Electronic Applications
Processing Method	• Injection Molding

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.18	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	11	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield, 3.20 mm)	52.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	> 50	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ³ (Yield, 3.20 mm)	85.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	490	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁴ 0.45 MPa, Unannealed, 6.40 mm	98.0	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+10 to 1.0E+11	ohms	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.6 mm, Black	V-2		
1.6 mm, White	V-2		

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	60 to 80	°C
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	< 0.020	%
Rear Temperature	210 to 240	°C
Middle Temperature	215 to 250	°C

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Lupoy® EC5000AF

LG Chem Ltd. - Polycarbonate + ABS

Injection	Nominal Value	Unit
Front Temperature	225 to 260	°C
Nozzle Temperature	220 to 250	°C
Processing (Melt) Temp	230 to 260	°C
Mold Temperature	50 to 70	°C
Screw Speed	40 to 70	rpm

Notes

¹ Typical properties: these are not to be construed as specifications.

² 50 mm/min

³ 10 mm/min

⁴ 4.6kg