

Lupoy® HP5004A

LG Chem Ltd. - Polycarbonate + ABS

Friday, May 24, 2019

General Information

Product Description

Description

General Purpose, Good Weld Properties, High Impact(at Low Temperature), Heat Resistance

Application

Mobile Phone Housing

General

Material Status	• Commercial: Active	
Availability	• Asia Pacific • Europe	• Latin America • North America
Features	• General Purpose • Good Heat Resistance	• Low Temperature Impact Resistance • Weldable
Uses	• Cell Phones	• Electrical Housing
Processing Method	• Injection Molding	

ASTM & ISO Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.14	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	4.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C, 3.20 mm, Injection Molded)	0.50 to 0.70	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ²			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	58.8	MPa	
Tensile Elongation ²			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	130	%	
Flexural Modulus ³ (23°C, 3.20 mm, Injection Molded)	2060	MPa	ASTM D790
Flexural Strength ³ (23°C, 3.20 mm, Injection Molded)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm, Injection Molded	490	J/m	
23°C, 3.20 mm, Injection Molded	640	J/m	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale, 23°C, Injection Molded)	113		ASTM D785
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁴			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	118	°C	
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.70 mm)	HB		UL 94

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Processing Information

Injection	Nominal Value	Unit
Drying Temperature	80 to 100	°C
Drying Time	3.0 to 5.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	240 to 250	°C
Middle Temperature	250 to 280	°C
Front Temperature	250 to 280	°C
Nozzle Temperature	250 to 280	°C
Processing (Melt) Temp	255 to 285	°C
Mold Temperature	80 to 100	°C
Back Pressure	0.981 to 3.92	MPa
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 18.6kg