

General Information
Product Description

Description

Good surface quality, Heat resistance

Application

Automotive bezel, Rear combi

General

Material Status	• Commercial: Active	
Availability	• Asia Pacific • Europe	• Latin America • North America
Features	• Good Heat Resistance	• Good Surface Finish
Uses	• Automotive Applications	
Processing Method	• Injection Molding	

ASTM & ISO Properties¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.15	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	5.3	g/10 min	ASTM D1238
Molding Shrinkage - Flow (23°C, 3.20 mm, Injection Molded)	0.50 to 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ²			ASTM D638
Yield, 23°C, 3.20 mm, Injection Molded	54.9	MPa	
Tensile Elongation ²			ASTM D638
Break, 23°C, 3.20 mm, Injection Molded	> 100	%	
Flexural Modulus ³ (23°C, 3.20 mm, Injection Molded)	2260	MPa	ASTM D790
Flexural Strength ³ (23°C, 3.20 mm, Injection Molded)	86.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm, Injection Molded	230	J/m	
23°C, 3.20 mm, Injection Molded	510	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm, Injection Molded	128	°C	
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 6.40 mm, Injection Molded	114	°C	

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	80 to 100	°C
Drying Time	4.0 to 6.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	240 to 270	°C
Middle Temperature	245 to 275	°C

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Lupoy® HR5007AT

LG Chem Ltd. - Polycarbonate + ABS

Injection	Nominal Value	Unit
Front Temperature	245 to 275	°C
Nozzle Temperature	245 to 275	°C
Processing (Melt) Temp	240 to 270	°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