

Lupox® LW5300M

Polycarbonate + PBT

LG Chem Ltd.

Message:

Description

Low Warpage

Application

Automotive(Head Lamp Bezel)

General Information			
Filler / Reinforcement	Mineral,30% Filler by Weight		
Features	Low Warpage		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.54	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	21	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.70 to 0.90	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.060	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	65.7	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	3.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	5880	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C ⁵	41	J/m	
23°C, 3.20 mm	44	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	165	°C	
1.8 MPa, Unannealed, 6.40 mm	120	°C	
Peak Melting Temperature	223	°C	ASTM D3418
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	255	°C	
Middle Temperature	255 to 260	°C	
Front Temperature	255 to 265	°C	

Nozzle Temperature	255 to 265	°C
Processing (Melt) Temp	245 to 255	°C
Mold Temperature	60.0 to 100	°C

NOTE		
1.	5.0 mm/min	
2.	5.0 mm/min	
3.	1.3 mm/min	
4.	1.3 mm/min	
5.	6.4 mm Notch Depth	

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