

# LUPOY ER2503FT

## (Tentative)

Injection Molding, PC/Glass fiber Reinforced, PCR contained

### Description

Halogen Free Flame Retardant  
Post Consumer Recycled content 30%  
High Stiffness

### Application

IT&OA (Notebook PC housing)

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.6
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1~0.2
Melt Flow Rate	260 °C, 5kg	ASTM D1238	g/10min	30
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	5 mm/min		kg/cm <sup>2</sup>	1,500
Flexural Strength, 3.2mm	1.3 mm/min	ASTM D790	kg/cm <sup>2</sup>	2,400
Flexural Modulus, 3.2mm	1.3 mm/min	ASTM D790	kg/cm <sup>2</sup>	150,000
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	kg·cm/cm	10
	-30°C		kg·cm/cm	
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	87
	4.6kg		°C	
Flammability		UL94		
	0.8mm		class	V-0
	1.0mm		class	V-0
3.0mm		class	V-0	
Relative Temperature Index		UL 746B		
	Electrical		°C	80
	Mechanical with Impact		°C	80
	Mechanical without Impact		°C	80

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 moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : August, 2020

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### Electrical

Property	Condition	Standard	Unit
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts
Surface Resistivity		IEC 60093	Ohm
Volume Resistivity	23°C	ASTM D257	Ohm·m
Arc Resistance	23°C	ASTM D495	Ohm·cm
Dielectric Strength, 1mm	23°C	ASTM D149	kV/mm
Dielectric Constant (10 <sup>6</sup> Hz)	23°C	ASTM D150	sec

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### Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 90
Drying Time		hrs	3 ~ 5
Maximum Moisture Content		%	0.04
Melt Temperature		°C	270 ~ 320
Cylinder Temperature	Rear	°C	270 ~ 290
	Middle	°C	280 ~ 310
	Front	°C	290 ~ 320
Nozzle Temperature		°C	290 ~ 320
Mold Temperature		°C	60 ~ 100
Back Pressure		kg/cm <sup>2</sup>	10 ~ 20
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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