SolutionPartner

LUPOL GP2200

Injection Molding, PP+GF20%

Description

General Purpose

Application

Electrical & Electronic, Automotive Parts

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.03
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4 ~ 0.6
Melt Flow Rate	230℃/2.16kg	ASTM D1238	g/10min	7
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	5mm/min		kg/cm^2	680
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	5mm/min		%	-
@ Break	5mm/min		%	5.0
Flexural Strength, 6.4mm	1.3mm/min	ASTM D790	kg/cm^2	1,000
Flexural Modulus, 6.4mm	1.3mm/min	ASTM D790	kg/cm^2	35,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	6.0
	-10℃		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	-
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	4.6kg		℃	-
	18.6kg		℃	150

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 molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : 20-Oct-15

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	70 ~ 80
Drying Time		hrs	3 ~ 4
Maximum Moisture Content		%	0.01
Melt Temperature		℃	210 ~ 240
Cylinder Temperature	Rear	℃	190 ~ 210
	Middle	℃	200 ~ 230
	Front	℃	200 ~ 230
Nozzle Temperature		℃	210 ~ 230
Mold Temperature		℃	40 ~ 60
Back Pressure		kg/cm^2	300 ~ 600
Screw Speed		rpm	30 ~ 60

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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