SolutionPartner

珍顺塑胶 ZhenShun Plastics

源博材料 YUANBO MATERIAL

LG Chem

LUPOL HI5302R

Injection Molding, PP+MF30%

Description

High Impact, Good Weatherability

Application

Automotive Interior Parts

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.12
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.8~1.0
Melt Flow Rate	230℃/2.16kg	ASTM D1238	g/10min	20
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm^2	220
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	-
@ Break	50mm/min		%	20
Flexural Strength, 6.4mm	10mm/min	ASTM D790	kg/cm^2	360
Flexural Modulus, 6.4mm	10mm/min	ASTM D790	kg/cm^2	23,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	5
	-10℃		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	
Thermal				
Heat Deflection Temperature, 3.2mm		ASTM D648		
(Unannealed)	4.6kg		℃	-
	18.6kg		℃	75

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 : 22-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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