SolutionPartner

LG Chem

LUPOX GP2150

Injection Molding, PBT+GF15%

Description

General Purpose

Application

IT/OA, E&E, Automotive (Connector)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.41
Molding Shrinkage		ASTM D955	%	0.4 ~ 1.1
Melt Flow Rate	250℃/2.16kg	ASTM D1238	g/10min	30
Water Absorption	23℃, 24hrs	ASTM D570	%	0.07
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm^2	950
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	5mm/min		%	-
@ Break	5mm/min		%	4.0
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	1,500
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	50,000
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	4.5
Thermal				
Melt Temperature		ASTM D3418	℃	223
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	205
	4.6kg		℃	210
Flammability		UL94	class	HB
0.71mm			class	HB
1.5mm			class	HB
3.3mm			class	HB
Relative Temperature Index		UL 746B		
Electrical			℃	140
Mechanical with Impact			℃	130
Mechanical without Impact			℃	140
Electrical				
Comparative Tracking Index(CTI)	Solution A	UL 746	PLC	1
Volume Resistivity	23℃	ASTM D257	Ohm·cm	1.0E+17
Arc Resistance	23℃	ASTM D495	PLC	6
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm	25

Note) All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : 1-Jul-14

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	120
Drying Time		hrs	4 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		℃	245 ~ 255
Cylinder Temperature	Rear	℃	235 ~ 250
	Middle	℃	240 ~ 250
	Front	℃	245 ~ 255
Nozzle Temperature		℃	245 ~ 255
Mold Temperature		℃	60 ~ 100
Back Pressure		kg/cm^2	-
Screw Speed		rpm	-

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.

Updated : 1-Jul-14