

LUMAX GN5006FC

Injection Molding, PBT+ABS

Description

Halogen Free Flame Retardant

Application

E&E(Connector)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.05
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.5 ~ 0.7
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	-
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	480
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	-
@ Break	50mm/min		%	13
Flexural Strength, 3.2mm	2.8mm/min	ASTM D790	kg/cm ²	720
Flexural Modulus, 3.2mm	2.8mm/min	ASTM D790	kg/cm ²	23,000
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg-cm/cm	15
Thermal				
Melt Temperature @ Break		ASTM D3418	°C	225
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	80
	4.6kg		°C	-
Flammability		UL94	class	
1.2 mm			class	V-2
1.5 mm			class	V-2
3.0 mm			class	V-2
Relative Temperature Index		UL 746B		
Electrical			°C	60
Mechanical with Impact			°C	60
Mechanical without Impact			°C	60
Electrical				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Volume Resistivity	23 °C	ASTM D257	Ohm-cm	-
Arc Resistance	23 °C	ASTM D495	sec	-
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	-

Note) All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Updated : 9-Nov-09

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80	
Drying Time	hrs	4 ~ 6	
Minimum Moisture Content	%	0.02	
Melt Temperature	°C	230 ~ 245	
Cylinder Temperature	Rear	°C	220 ~ 230
	Middle	°C	225 ~ 235
	Front	°C	225 ~ 235
Nozzle Temperature	°C	230 ~ 245	
Mold Temperature	°C	40 ~ 60	
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.

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