SolutionPartner

LG Chem

LUMAX GP5200B

Injection Molding, PBT+ABS+GF20%

Description

General Purpose

Application

E&E(Speaker Frame)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.35
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4 ~ 0.9
Melt Flow Rate	250℃/2.16kg	ASTM D1238	g/10min	-
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	5mm/min		kg/cm^2	950
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	5mm/min		%	-
@ Break	5mm/min		%	3.0
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	1,450
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	58,000
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	6.5
Thermal				
Melt Temperature @ Break		ASTM D3418	℃	225
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	160
	4.6kg		℃	195
Flammability		UL94	class	-
Relative Temperature Index		UL 746B		
Electrical			℃	-
Mechanical with Impact			℃	-
Mechanical without Impact			℃	-
Electrical				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Surface Resistivity		IEC 60093	Ohm	-
Volume Resistivity	23℃	ASTM D257	Ohm·cm	-
Arc Resistance	23℃	ASTM D495	sec	-
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm	-

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

Updated : 9-Nov-09

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100
Drying Time		hrs	4 ~ 5
Minimum Moisture Content		%	0.02
Melt Temperature		℃	240 ~ 250
Cylinder Temperature	Rear	℃	225 ~ 245
	Middle	℃	230 ~ 250
	Front	℃	240 ~ 250
Nozzle Temperature		℃	240 ~ 250
Mold Temperature		℃	60 ~ 80
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 : 9-Nov-09