

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 °C/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 (Notched)	23 °C	ASTM D256	kg-cm/cm	6.5
Thermal				
Melt Temperature @ Break		ASTM D3418	°C	225
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	160
	4.6kg		°C	195
Flammability		UL94	class	-
Relative Temperature Index		UL 746B		
Electrical			°C	-
Mechanical with Impact			°C	-
Mechanical without Impact			°C	-
Electrical				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Surface Resistivity		IEC 60093	Ohm	-
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

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.

LUMAX GP5200B

Injection Molding, PBT+ABS+GF20%

Description

General Purpose

Application

E&E(Speaker Frame)

Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	100	
Drying Time	hrs	4 ~ 5	
Minimum Moisture Content	%	0.02	
Melt Temperature	°C	240 ~ 250	
Cylinder Temperature	Rear	°C	225 ~ 245
	Middle	°C	230 ~ 250
	Front	°C	240 ~ 250
Nozzle Temperature	°C	240 ~ 250	
Mold Temperature	°C	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.