

LUMAX HR5157

Injection Molding, PBT+ABS+GF15%

Description

Heat Resistance

Application

E&E(CD ROM Tray)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.33
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	790
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	1,300
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	45,000
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	8.0
Thermal				
Melt Temperature @ Break		ASTM D3418	°C	225
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	175
	4.6kg		°C	-
Flammability		UL94		
1.5mm			class	HB
3.0mm			class	HB
Relative Temperature Index		UL 746B		
Electrical			°C	50
Mechanical with Impact			°C	50
Mechanical without Impact			°C	50
Electrical				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	250
Volume Resistivity	23 °C	ASTM D257	Ohm·cm	1.0E+15
Arc Resistance	23 °C	ASTM D495	sec	-
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	21

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

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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	245 ~ 255	
Cylinder Temperature	Rear	°C	225 ~ 235
	Middle	°C	230 ~ 245
	Front	°C	245 ~ 255
Nozzle Temperature	°C	245 ~ 255	
Mold Temperature	°C	60 ~ 90	
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.