

# LUPOX LW5300M

Injection Molding, PBT+PC+MF30%

## Description

Low Warpage

## Application

Automotive(Head Lamp Bezel)

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.54
Molding Shrinkage		ASTM D955	%	0.7 ~ 0.9
Melt Flow Rate	265 °C/2.16kg	ASTM D1238	g/10min	21
Water Absorption	23 °C, 24hrs	ASTM D570	%	0.06
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm <sup>2</sup>	670
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	5mm/min		%	-
@ Break	5mm/min		%	3.0
Flexural Strength, 6.4mm	5mm/min	ASTM D790	kg/cm <sup>2</sup>	1,100
Flexural Modulus, 6.4mm	5mm/min	ASTM D790	kg/cm <sup>2</sup>	60,000
IZOD Impact Strength, 6.4mm		ASTM D256		
(Notched)	23 °C		kg·cm/cm	4.2
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23 °C		kg·cm/cm	4.5
<b>Thermal</b>				
Melt Temperature		ASTM D3418	°C	223
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		°C	120
	4.6kg		°C	165
Flammability		UL94	class	-
Relative Temperature Index		UL 746B		
Electrical			°C	-
Mechanical with Impact			°C	-
Mechanical without Impact			°C	-
<b>Electrical</b>				
Comparative Tracking Index(CTI)	Solution A	UL 746	PLC	-
Volume Resistivity	23 °C	ASTM D257	Ohm·cm	-
Arc Resistance	23 °C	ASTM D495	PLC	-
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	-

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

Updated : 1-Jul-14

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.

# LUPOX LW5300M

Injection Molding, PBT+PC+MF30%

## Description

Low Warpage

## Application

Automotive(Head Lamp Bezel)

### Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	120	
Drying Time	hrs	4 ~ 5	
Maximum Moisture Content	%	0.02	
Melt Temperature	°C	245 ~ 255	
Cylinder Temperature	Rear	°C	255 ~ 255
	Middle	°C	255 ~ 260
	Front	°C	255 ~ 265
Nozzle Temperature	°C	255 ~ 265	
Mold Temperature	°C	60 ~ 100	
Back Pressure	kg/cm <sup>2</sup>	-	
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

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.