

LUPOX SG3250

Injection Molding, PBT+PET+MF25%

Description

Good Surface

Application

Automotive(Head Lamp Bezel)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.54
Molding Shrinkage		ASTM D955	%	0.5 ~ 1.2
Melt Flow Rate	265 °C/2.16kg	ASTM D1238	g/10min	41
Water Absorption	23 °C, 24hrs	ASTM D570	%	0.06
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm ²	540
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	5mm/min		%	-
@ Break	5mm/min		%	2.1
Flexural Strength, 6.4mm	5mm/min	ASTM D790	kg/cm ²	920
Flexural Modulus, 6.4mm	5mm/min	ASTM D790	kg/cm ²	52,000
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg·cm/cm	3.0
Thermal				
Melt Temperature		ASTM D3418	°C	223
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	105
	4.6kg		°C	205
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	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

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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	255 ~ 265	
Cylinder Temperature	Rear	°C	245 ~ 255
	Middle	°C	250 ~ 260
	Front	°C	255 ~ 265
Nozzle Temperature	°C	255 ~ 265	
Mold Temperature	°C	80 ~ 100	
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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