SolutionPartner

LG Chem

LUPOX HI1002F

Injection Molding, PBT+PC

Description

Flame Retardant, High Impact

Application

IT/OA, E&E(Switch)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.33
Molding Shrinkage		ASTM D955	%	0.9 ~ 1.3
Melt Flow Rate	250℃/2.16kg	ASTM D1238	g/10min	4
Water Absorption	23℃, 24hrs	ASTM D570	%	0.08
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm^2	500
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	50mm/min		%	-
@ Break	50mm/min		%	> 50
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	740
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm^2	20,000
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		kg·cm/cm	70.0
Thermal				
Melt Temperature		ASTM D3418	℃	223
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	90
	4.6kg		℃	
Flammability		UL94		
0.75 mm			class	V-0
1.5 mm			class	V-0
2.0 mm			class	V-0
2.3 mm			class	V-0, 5VA
3.0 mm			class	V-0, 5VA
Relative Temperature Index		UL 746B		
Electrical			℃	130
Mechanical with Impact			℃	120
Mechanical without Impact			℃	120
Electrical				
Comparative Tracking Index(CTI)	Solution A	UL 746	PLC	2
Volume Resistivity	23℃	ASTM D257	Ohm·cm	
Arc Resistance	23℃	ASTM D495	PLC	5
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 : 1-Jul-14

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100 ~ 120
Drying Time		hrs	4 ~ 6
Maximum Moisture Content		%	0.02
Melt Temperature		℃	250 ~ 265
Cylinder Temperature	Rear	℃	240 ~ 245
	Middle	℃	245 ~ 250
	Front	℃	250 ~ 255
Nozzle Temperature		℃	250 ~ 265
Mold Temperature		℃	40 ~ 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 : 1-Jul-14