

# LUPOX HI2152

Injection Molding, PBT+GF15%

## Description

High Impact

## Application

IT/OA, E&E(Bobbin, Switch)

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.39
Molding Shrinkage		ASTM D955	%	0.7 ~ 1.1
Melt Flow Rate	250 °C/2.16kg	ASTM D1238	g/10min	26
Water Absorption	23 °C, 24hrs	ASTM D570	%	0.07
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm <sup>2</sup>	850
Tensile Elongation, 3.2mm		ASTM D638		
@ Yield	5mm/min		%	-
@ Break	5mm/min		%	4.0
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm <sup>2</sup>	1,400
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm <sup>2</sup>	43,000
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg·cm/cm	5.0
<b>Thermal</b>				
Melt Temperature		ASTM D3418	°C	223
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	195
	4.6kg		°C	-
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 moulded 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 HI2152

Injection Molding, PBT+GF15%

## Description

High Impact

## Application

IT/OA, E&E(Bobbin, Switch)

### 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	235 ~ 250
	Middle	°C	240 ~ 250
	Front	°C	245 ~ 255
Nozzle Temperature		°C	245 ~ 255
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.