

LUPOX SG5300

Injection Molding, PBT+PET+GF30%

Description

Good Surface

Application

E&E, Automotive(Switch)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.54
Molding Shrinkage		ASTM D955	%	0.4 ~ 1.0
Melt Flow Rate	265 °C/2.16kg	ASTM D1238	g/10min	27
Water Absorption	23 °C, 24hrs	ASTM D570	%	0.06
Mechanical				
Tensile Strength, 3.2mm @ Break	5mm/min	ASTM D638	kg/cm ²	1,200
Tensile Elongation, 3.2mm @ Break	5mm/min	ASTM D638	%	4.0
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	1,900
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	90,000
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg·cm/cm	6.5
Thermal				
Melt Temperature		ASTM D3418	°C	223
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C °C	205 215
Flammability 1.5mm		UL94	class	HB
Relative Temperature Index Electrical Mechanical with Impact Mechanical without Impact		UL 746B	°C °C °C	75 75 75
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 moulded 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	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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