

Lupos® GP2305A

Styrene Acrylonitrile

LG Chem Ltd.

Message:

- Description
- General Purpose
- Applications
- Electric & Electronic (Housing, Components)

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	General		
Uses	Electrical/Electronic Applications		
	General		
	Shell		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.31	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (250°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.10 - 0.20	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	108	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	3.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	8830	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	152	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	101	°C	ASTM D648
RTI Elec	50.0	°C	UL 746
RTI Imp	50.0	°C	UL 746
RTI	50.0	°C	UL 746
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	3.0 - 4.0	hr	

Rear Temperature	220 - 235	°C
Middle Temperature	220 - 240	°C
Front Temperature	220 - 240	°C
Nozzle Temperature	230 - 245	°C
Processing (Melt) Temp	235 - 245	°C
Mold Temperature	50.0 - 80.0	°C
Back Pressure	0.981 - 3.92	MPa
Screw Speed	40 - 80	rpm

Injection instructions

Minimum Moisture Content: 0.02%

NOTE

1.	50 mm/min
2.	50 mm/min
3.	10 mm/min
4.	10 mm/min

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