

Lucon® PX6101F

Polybutylene Terephthalate

LG Chem Ltd.

Message:

Description

Antistatic

Flame Retardant

Application

Copy Machine Paper guide

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
	Carbon nano filler		
Additive	Antistatic property		
Features	Antistatic property		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.45	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (220°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.20 - 0.40	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	98.1	MPa	ASTM D638
Flexural Modulus ² (3.20 mm)	7010	MPa	ASTM D790
Flexural Strength ³ (3.20 mm)	137	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	49	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	185	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+8 - 1.0E+10	ohms	IEC 60093
Injection	Nominal Value	Unit	
Drying Temperature	80 - 100	°C	
Drying Time	4.0 - 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	230 - 240	°C	
Middle Temperature	245 - 255	°C	
Front Temperature	250 - 260	°C	

Nozzle Temperature	250 - 260	°C
Processing (Melt) Temp	250 - 260	°C
Mold Temperature	60 - 90	°C
Back Pressure	0.981 - 3.92	MPa
Screw Speed	40 - 70	rpm

NOTE

- | | |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 10 mm/min |
| 3. | 10 mm/min |

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