

Lupol® HF5254A

Compounded Polypropylene

LG Chem Ltd.

Message:

Description

Good Weatherability

Application

Automotive Interior Parts

General Information			
Filler / Reinforcement	Mineral,20% Filler by Weight		
Features	Good Weather Resistance		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	30	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.80 to 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	30.4	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	20	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2840	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	44.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-10°C, 6.40 mm	39	J/m	
23°C, 6.40 mm	49	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 3.20 mm)	130	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 80.0	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	< 0.010	%	
Rear Temperature	190 to 210	°C	
Middle Temperature	200 to 230	°C	
Front Temperature	200 to 230	°C	
Nozzle Temperature	210 to 230	°C	
Processing (Melt) Temp	200 to 230	°C	
Mold Temperature	40.0 to 60.0	°C	
Back Pressure	29.4 to 58.8	MPa	

Screw Speed	30 to 60	rpm
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	30 mm/min	
4.	30 mm/min	
5.	4.6kg	

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