

Lupol® GP3300

Polypropylene

LG Chem Ltd.

Message:

LUPOL GP-3303 is designed for injection molding of large parts by reinforced with mineral filler. This product features excellent dimensional stability and low warpage characteristics, thus ideal for interior materials of automobiles, and electric/electronic parts.

General Information			
UL YellowCard	E67171-248655	E248280-322200	
Filler / Reinforcement	Mineral filler, 30% filler by weight		
Features	Good dimensional stability		
	Low warpage		
	High strength		
	General		
Uses	Electrical/Electronic Applications		
	Electrical components		
	Application in Automobile Field		
	Car interior parts		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.70 - 1.1	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	90		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	35.3	MPa	ASTM D638
Tensile Elongation (Break)	20	%	ASTM D638
Flexural Modulus	3430	MPa	ASTM D790
Flexural Strength (Yield)	54.9	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	145	°C	ASTM D648
1.8 MPa, not annealed	95.0	°C	ASTM D648
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
Hopper Temperature	50.0 - 57.0	°C
Rear Temperature	190 - 210	°C
Middle Temperature	207 - 222	°C
Front Temperature	211 - 228	°C
Nozzle Temperature	205 - 220	°C
Mold Temperature	50.0 - 57.0	°C
Injection Pressure	2.94 - 11.8	MPa
Injection Rate	Fast	
Back Pressure	1.47 - 5.88	MPa
Screw Speed	40 - 60	rpm
Injection instructions		

Secondary Injection Pressure: 20 to 100 kg/cm²

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