

Lupol® GP3156F

Polypropylene

LG Chem Ltd.

Message:

LUPOL GP-3156F 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.

Applications:

Automobile interior, electric/electronic components.

General Information			
UL YellowCard	E248280-100040782	E248280-100696385	E302314-530062
	E67171-480006		
Filler / Reinforcement	Mineral filler		
Features	General		
	Flame retardancy		
Uses	Electrical/Electronic Applications		
	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	6.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.90 - 1.3	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	27.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	20	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1770	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	38.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	49	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.20 mm)	135	°C	ASTM D648
RTI Elec	125	°C	UL 746
RTI Imp	120	°C	UL 746
RTI	120	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating (0.794 mm)	V-0	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	70.0 - 80.0	°C	

Drying Time	3.0 - 4.0	hr
Minimum Moisture Content	> 0.010	%
Rear Temperature	190 - 210	°C
Middle Temperature	200 - 230	°C
Front Temperature	200 - 230	°C
Nozzle Temperature	210 - 230	°C
Processing (Melt) Temp	200 - 230	°C
Mold Temperature	40.0 - 60.0	°C
Back Pressure	29.4 - 58.8	MPa
Screw Speed	30 - 60	rpm

Injection instructions

First injection pressure: 30 to 120 kg/cm² Second injection pressure: 20 to 100 kg/cm²

NOTE

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

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