

Lupol® HM5204

Compounded Polypropylene

LG Chem Ltd.

Message:

Description

Good Weatherability, High Impact

Application

Automotive Interior Parts

General Information			
Filler / Reinforcement	Mineral,20% Filler by Weight		
Features	Good Weather Resistance		
	High Impact Resistance		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.04	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	7.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.90 to 1.1	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	25.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	80	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2350	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	41.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-10°C, 6.40 mm	49	J/m	
23°C, 6.40 mm	180	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 3.20 mm)	135	°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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