

Lupox® SG3250M

Polybutylene Terephthalate + PET

LG Chem Ltd.

Message:

Description
Good Surface
Application
Automotive(Head Lamp Bezel)

General Information			
Features	Good Surface Finish		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	41	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.50 to 1.2	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.060	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	49.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	2.0	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	5000	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	80.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	28	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm)	200	°C	ASTM D648
Peak Melting Temperature	223	°C	ASTM D3418
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	245 to 255	°C	
Middle Temperature	250 to 260	°C	
Front Temperature	255 to 265	°C	
Nozzle Temperature	255 to 265	°C	
Processing (Melt) Temp	255 to 265	°C	
Mold Temperature	80.0 to 100	°C	
NOTE			
1.	5.0 mm/min		

2.	5.0 mm/min
3.	5.0 mm/min
4.	5.0 mm/min

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