

Lupox® SG3250

Polybutylene Terephthalate

LG Chem Ltd.

Message:

Description
Good Surface
Application
Automotive (Head Lamp Bezel)

General Information			
Features	Good Surface Finish		
Uses	Automotive Applications		
	Automotive Exterior Trim		
Processing Method	Injection Molding		
Multi-Point Data	Specific Heat vs. Temperature (ISO 11403-2)		
	Viscosity vs. Shear Rate (ISO 11403-2)		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.54	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)	53.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	2.1	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	5100	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	90.2	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	29	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	205	°C	
1.8 MPa, Unannealed, 6.40 mm	105	°C	
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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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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