

Lupol® GP3402

Polypropylene

LG Chem Ltd.

Message:

Description

General Purpose

Application

Automotive Interior Parts

General Information			
UL YellowCard	E248280-534671	E67171-248666	
Filler / Reinforcement	Mineral,40% Filler by Weight		
Features	General Purpose		
Uses	Automotive Applications		
	Automotive Interior Parts		
UL File Number	E67171		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	10	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.60 to 1.0	%	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)	15	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	3630	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	43.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.20 mm)	140	°C	ASTM D648
RTI Elec (1.50 mm)	65.0	°C	UL 746
RTI Imp (1.50 mm)	65.0	°C	UL 746
RTI Str (1.50 mm)	65.0	°C	UL 746
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm, ALL)	HB	UL 94	
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 |

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