

Lupol® HF5150H

Compounded Polypropylene

LG Chem Ltd.

Message:

Description
High Flow
Application
Automotive Interior parts

General Information			
Filler / Reinforcement	Mineral,15% Filler by Weight		
Features	High Flow		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.01	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	100	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.1 to 1.5	%	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)	10	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1770	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	36.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-10°C, 6.50 mm	20	J/m	
23°C, 6.40 mm	39	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 3.20 mm)	130	°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
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NOTE

1.	50 mm/min
2.	50 mm/min
3.	30 mm/min
4.	30 mm/min

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