

Lumiloy® GN1306F

Polyphenylene Ether + PS

LG Chem Ltd.

Message:

Injection Molding Grade, Flame Retardant mPPO

Description

General Purpose, High Heat Resistance

Application

Electric and Electronic Parts

General Information			
Features	Flame Retardant		
	General Purpose		
	High Heat Resistance		
Uses	Electrical/Electronic Applications		
	General Purpose		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	8.0	g/10 min	ASTM D1238
Water Absorption (23°C, 24 hr)	0.30	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	68.6	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	20	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2450	MPa	ASTM D790
Flexural Strength ⁴ (Break, 3.20 mm)	118	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-40°C, 3.20 mm	78	J/m	
-30°C, 3.20 mm	98	J/m	
23°C, 3.20 mm	200	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	135	°C	ASTM D648
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.800 mm	V-0		
1.50 mm	V-0		

V-0

2.00 mm

5VA

V-0

3.00 mm

5VA

Injection	Nominal Value	Unit
Drying Temperature	90.0 to 100	°C
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	> 0.010	%
Rear Temperature	250 to 280	°C
Middle Temperature	260 to 290	°C
Front Temperature	260 to 300	°C
Nozzle Temperature	260 to 300	°C
Processing (Melt) Temp	270 to 300	°C
Mold Temperature	80.0 to 100	°C

NOTE

- | | |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 10 mm/min |
| 4. | 10 mm/min |

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