

Lupol® MC4352

Compounded Polypropylene

LG Chem Ltd.

Message:

Description

Good Dimensional Stability, Scratch resistance, Good Weatherability, High Impact

Application

Automotive Exterior(Sill Side Molding, Door Garnish)

General Information			
Filler / Reinforcement	Mineral		
Additive	Rubber Impact Modifier		
Features	Good Dimensional Stability		
	Good Weather Resistance		
	High Impact Resistance		
	Scratch Resistant		
Uses	Automotive Exterior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.10	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	21	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	5.0 to 6.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	16.7	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1670	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	27.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 6.40 mm	44	J/m	
23°C, 6.40 mm	390	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 3.20 mm)	120	°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

NOTE

1. 50 mm/min
2. 50 mm/min
3. 10 mm/min
4. 10 mm/min
5. 4.6kg

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