Lupol® HI5204

Compounded Polypropylene

LG Chem Ltd.

Message:

Description
High Impact, Good Weatherability
Application
Automotive Interior Parts

General Information			
Filler / Reinforcement	Mineral,20% Filler by Weight		
Features	Good Weather Resistance High Impact Resistance		
Uses	Automotive Interior Parts		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.06	g/cm³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.1 to 1.3	%	ASTM D955
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (Yield, 3.20 mm)	25.0	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	85	%	ASTM D638
Flexural Modulus [3] (6.40 mm)	2260	MPa	ASTM D790
Flexural Strength [4] (Yield, 6.40 mm)	37.3	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-10°C, 6.40 mm	44	J/m	
23°C, 6.40 mm	200	J/m	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load [5] (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

NOTE	
1.	50 mm/min
2.	50 mm/min
3.	30 mm/min
4.	30 mm/min
5.	4.6kg

Recommended distributors for this material

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