

Lupox® HI2303

Polycarbonate + PBT

LG Chem Ltd.

Message:

Description
High Impact
Application
IT/OA, E&E(Bobbin, Switch)

General Information			
Features	High Impact Resistance		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (265°C/2.16 kg)	5.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow	0.30 to 1.0	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.080	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	93.2	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	3.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	6370	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	147	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	190	°C	
1.8 MPa, Unannealed, 6.40 mm	170	°C	
Peak Melting Temperature	223	°C	ASTM D3418
Injection	Nominal Value	Unit	
Drying Temperature	120	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	235 to 250	°C	
Middle Temperature	240 to 250	°C	
Front Temperature	245 to 255	°C	
Nozzle Temperature	245 to 255	°C	
Processing (Melt) Temp	245 to 255	°C	
Mold Temperature	60.0 to 100	°C	

NOTE	
1.	5.0 mm/min
2.	5.0 mm/min
3.	1.3 mm/min
4.	1.3 mm/min

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