

Lupos HR2207A

Acrylonitrile Butadiene Styrene

LG Chem Ltd.

Message:

Description
General Purpose, Heat Resistance
Application
Electric & Electronic (Housing, Components)

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	General Purpose		
	Medium Heat Resistance		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (230°C/2.16 kg)	2.0	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.30	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	78.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	2.5	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	5880	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	118	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	105	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	3.0 to 4.0	hr	
Suggested Max Moisture	< 0.020	%	
Rear Temperature	220 to 235	°C	
Middle Temperature	220 to 240	°C	
Front Temperature	220 to 240	°C	
Nozzle Temperature	230 to 245	°C	
Processing (Melt) Temp	235 to 245	°C	

Mold Temperature	50.0 to 80.0	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 80	rpm

NOTE

- | | |
|----|-----------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 10 mm/min |
| 4. | 10 mm/min |
| 5. | 18.6kg |

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