

SolutionPartner
 **LG Chem**

LG709W

Injection Molding

Description

- Low Gloss, Heat Resistance

Applications

- Automotive Interior Housing(Sun-Visor Mirror Cover Etc)

Properties	Method	Unit	LG709W
Physical			
Specific Gravity , 23°C	ASTM D792		1.04
Mold Shrinkage , 23°C, 3.2mm , 23°C	ASTM D955	%	0.4 ~ 0.7
Melt Flow Rate , 220°C, 10kg	ASTM D1238	g/10min	3
Mechanical			
Tensile Strength at Yield , 23°C, 50mm/min, 3.2mm	ASTM D638	Mpa	43
Tensile Elongation at Break , 23°C, 50mm/min, 3.2mm	ASTM D638	%, (Min)	10
Tensile Modulus , 23°C, 50mm/min, 3.2mm	ASTM D638	MPa	2000
Flexural Strength , 23°C, 15mm/min, 3.2mm	ASTM D790	Mpa	70
Flexural Modulus , 23°C, 15mm/min, 3.2mm	ASTM D790	MPa	2150
Izod Impact Strength , Notched, 3.2mm, 23°C	ASTM D256	J/m	155
Izod Impact Strength , Notched, 3.2mm, -30°C	ASTM D256	J/m	60
Izod Impact Strength , Notched, 6.4mm, 23°C	ASTM D256	J/m	135
Izod Impact Strength , Notched, 6.4mm, -30°C	ASTM D256	J/m	50
Rockwell Hardness , R-Scale	ASTM D785		108
Thermal			
HDT , Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	°C	106
VICAT , 50N, 50°C/h	ASTM D1525	°C	114

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors. Values given should not be interpreted as specification and not be used for designing part or tool. All properties, except melt flow rate are measured by injection molded specimens after 48 hours storage at 23°C, 50% relative humidity.

Updated Date : 1-Jul-17 Issued Date : 7-Mar-18

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Maximum Moisture Content	%	0.05 ~ 0.05
Melt Temperature	°C	220 ~ 250
Cylinder Temperature , Rear	°C	180 ~ 200
Cylinder Temperature, Middle	°C	200 ~ 220
Cylinder Temperature , Front	°C	220 ~ 230
Nozzle Temperature	°C	220 ~ 230
Mold Temperature	°C	40 ~ 60
Back Pressure, Hydraulic Type	kg/cm ²	10 ~ 30

Note

Back Pressure & Measuring Speed are only mentioned as general guidelines. These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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