Iupilon -Basic Properties-

				Glass Fiber Reinforced (Flame Retardant)-2
Properties	Test Method	Terms	Units	EGN2030KR
				Non Br & Non P 'High Flowability
				GF
				30%
				-
Physical properties				
Density	ISO 1183	-	g/cm³	1.43
Water absorption		23degC, 50%RH 23degC, Underwater	%	- 0.09
Rheological properties				
Melt Mass-flow Rate	ISO 1133		g/10min	-
Melt Volume-flow Rate		 Temperature Load	cm³/10min degC kgf	- 300 1.20
Moulding shrinkage (3.2mmt)	-	MD TD	%	0.1-0.3 0.2-0.4
Mechanical properties				
Tensile modulus	ISO 527-1 , 527-2		MPa	-
Yield stress				-
Yield strain			%	-
Nominal strain at break		-		-
Stress at 50% strain			MPa	-
Stress at break				100
Strain at break			%	2.3
Flexural strength	ISO 178	-	MPa	153
Flexural modulus				8000
Charpy impact strength	ISO 179-1, 179-2	23 degC	kJ/m²	32
Charpy notched impact strength	ISO 179-1, 179-2	23 degC	kJ/m²	9
Thermal properties				
Temperature of deflection under load	ISO 75-1 , 75-2	1.80MPa 0.45MPa	degC	140 144
Coefficient of Linear thermal expansion	ISO 11359-2	MD TD	1/degC	- -
Flammability	UL94	-	-	V-0(1.5mm) V-2(0.75mm)
Electrical properties				
Relative permittivity	IEC 60250	100Hz 1MHz	- -	- -
Dissipation factor	IEC 60250	100Hz 1MHz	- -	- -
Volume resistivity	IEC 60093	-	ohm-m	-

Surface resistivity	IEC 60093	-	ohm	-
Electric strength	IEC 602431	1mmt 2mmt 3mmt	MV/m	- - -
Comparative tracking index (CTI)	UL746A	-	-	same as 3
Note				
Molding conditions -Examples of recommended molding conditions are shown below.-				
Drying of feedstock resin				Hot air drying at 120℃---about 4-8 hours
Cylinder temp (rear)			℃	270-290
Cylinder temp (center)			℃	280-300
Cylinder temp (front)			℃	280-300
Nozzle temp			℃	280-300
Mold temp			℃	80-120
Injection pressure			MPa	50-150
Screw rotation			rpm	50-100