SolutionPartner

LG Chem

XR404T

Description

XR404T is engineered for rear combination lamp housings and has high welding strength with PMMA

Key Features

High Heat Resistance, Welding, Superior Surface Quality, Welding Strength

Application

Rear Combination Lamp

Properties	Condition	Method	Unit	XR404T
Physical				
Specific Gravity	23℃	ASTM D792		1.05
Mold Shrinkage	23℃, 3.2mm	ASTM D955	%	0.4 ~ 0.7
Melt Flow Index	220℃, 10kg	ASTM D1238	g/10min	6.5
Mechanical				
Tensile Strength at Yield	23℃, 50mm/min, 3.2mm	ASTM D638	MPa	53
Tensile Elongation at Break	23℃, 50mm/min, 3.2mm	ASTM D638	%, (Min)	15
Tensile Modulus	23℃, 50mm/min, 3.2mm	ASTM D638	MPa	2600
Izod Impact Strength	Notched, 3.2mm, 23℃	ASTM D256	J/m	180
Izod Impact Strength	Notched, 3.2mm, -30℃	ASTM D256	J/m	70
Izod Impact Strength	Notched, 6.4mm, 23℃	ASTM D256	J/m	170
Izod Impact Strength	Notched, 6.4mm, -30℃	ASTM D256	J/m	60
Rockwell Hardness	R-Scale	ASTM D785		111
Thermal				
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Unannealed	ASTM D648	℃	102
Heat Deflection Temperature	Edgewise, 0.46MPa, 6.4mm, Unannealed	ASTM D648	℃	111
Heat Deflection Temperature	Edgewise, 1.82MPa, 6.4mm, Annealed	ASTM D648	℃	109
Heat Deflection Temperature	Edgewise, 0.46MPa, 6.4mm, Annealed	ASTM D648	℃	113
Vicat Softening Temperature	50N, 50℃/h	ASTM D1525	℃	112
Flammability	3.0mm	UL 94		HB

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 index are measured by injection molded specimens after 48 hours storage at 23℃, 50% relative humidity.

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	℃	80 ~ 90
Drying Time	hrs	3 ~ 4
Injection Temperature	℃	220 ~ 290
Mold Temperature	℃	40 ~ 80
Screw Speed	rpm	30 ~ 60

Note

Injection Temperature & Screw 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.