

# LI941

## Description

LI941 has well-balanced properties with high heat, targeted for injection molding

## Key Features

Standard Purpose, High Heat  
Resistance, Non Painting,  
Weatherability

## Application

Antenna,Bumper,Others,Outside  
Mirror,Roller,Spoiler,Tractor,Window  
Profile

## Plant

USA(Ohio)

Properties	Condition	Method	Unit	LI941
<b>Physical</b>				
Specific Gravity	23°C	ISO 1183		1.08
Mold Shrinkage	23°C, 3.2mm	ISO 294-4	%	0.4 ~ 0.7
Melt Flow Rate	220°C, 10kg	ISO 1133	g/10min	6.5
<b>Mechanical</b>				
Tensile Strength at Yield	23°C, 50mm/min, 4mm	ISO 527	MPa	48
Tensile Elongation at Yield	23°C, 50mm/min, 4mm	ISO 527	%, (Min)	5
Tensile Elongation at Break	23°C, 50mm/min, 4mm	ISO 527	%, (Min)	15
Flexural Strength	23°C, 2mm/min, 4mm	ISO 178	MPa	75
Flexural Modulus	23°C, 2mm/min, 4mm	ISO 178	MPa	2400
Izod Impact Strength	Notched, 4mm, 23°C	ISO 180/1A	kJ/m <sup>2</sup>	10
Izod Impact Strength	Notched, 4mm, -30°C	ISO 180/1A	kJ/m <sup>2</sup>	2
Charpy Impact Strength	Notched, 4mm, 23°C	ISO 179/1eA	kJ/m <sup>2</sup>	10
Charpy Impact Strength	Notched, 4mm, -30°C	ISO 179/1eA	kJ/m <sup>2</sup>	2
Rockwell Hardness	R-Scale	ISO 2039		104
<b>Thermal</b>				
Heat Deflection Temperature	Flatwise, 1.8MPa, 4mm, Unannealed	ISO 75	°C	88
Heat Deflection Temperature	Flatwise, 0.45MPa, 4mm, Unannealed	ISO 75	°C	101
Heat Deflection Temperature	Flatwise, 1.8MPa, 4mm, Annealed	ISO 75	°C	98
Heat Deflection Temperature	Flatwise, 0.45MPa, 4mm, Annealed	ISO 75	°C	106
Vicat Softening Temperature	50N, 50°C/h	ISO 306	°C	102
Flammability	1.5mm	UL 94		HB
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°C, 50% relative humidity.

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## Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 90
Drying Time	hrs	3 ~ 4
Injection Temperature	°C	220 ~ 270
Mold Temperature	°C	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.