

# LUMILOY GP2200

Injection Molding Grade, General Purpose

## Description

GF 20% Reinforced  
NSF Certified for KA02 and E2035  
High Flow, High Impact Strength  
Hydrolytic Stability

## Application

Electric and Electronic parts  
Part for Water contact  
Water pump Housing or Impellers

Properties	Test Condition	Test Method	Unit	Typical Property
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.18
Mold Shrinkage (flow)		LG Method	%	0.2 ~ 0.5
Water Absorption	23°C, 24hrs	ASTM D570	%	0.06
Melt Flow Rate	280°C/5kg	ASTM D1238	g/10min	9
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm <sup>2</sup>	1100
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	50mm/min		%	7
Tensile Modulus, 3.2mm	1mm/min	ASTM D638	Mpa	5,500
Flexural Strength, 3.2mm	10mm/min	ASTM D790	kg/cm <sup>2</sup>	1,500
Flexural Modulus, 3.2mm	10mm/min	ASTM D790	kg/cm <sup>2</sup>	52,000
Rockwell Hardness	L-scale	ASTM D785	-	112
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23°C		kg·cm/cm	11.0
(Unnotched)	23°C		kg·cm/cm	46
<b>Thermal</b>				
Heat Deflection Temperature, 3.2mm		ASTM D648		
(Unannealed)	18.6kg		°C	140
Flammability		UL94		
0.8mm			class	HB
1.6mm			class	HB
2.5mm			class	HB
3.2mm			class	HB

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23°C, 50% relative humidity.

Updated : 1-Aug-14

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## Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 100
Drying Time		hrs	4 ~ 5
Maximum Moisture Content		%	0.02
Melt Temperature		°C	280 ~ 320
Cylinder Temperature	Rear	°C	260 ~ 300
	Middle	°C	270 ~ 310
	Front	°C	270 ~ 310
Nozzle Temperature		°C	270 ~ 310
Mold Temperature		°C	70 ~ 110

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