

LUSEP GP2400

Injection Molding, PPS+GF40%

Description

General Purpose

Application

Pump Units, Motor Units, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.65
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.2
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm ²	1,750
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	1 ~ 2
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	2,500
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	150,000
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	kg-cm/cm	8.5
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)		ASTM D648		
	18.6kg		℃	>260
	4.6kg		℃	>260
Flammability		UL94	class	
0.75mm			class	V-0
Electrical				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm	-

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

Updated : 9-Nov-09

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	100 ~ 120
Drying Time	hrs	2 ~ 4
Minimum Moisture Content	%	0.02
Melt Temperature	°C	300 ~ 330
Cylinder Temperature	Rear	°C 300
	Middle	°C 310
	Front	°C 320
Nozzle Temperature	°C	330
Mold Temperature	°C	120 ~ 150
Back Pressure	kg/cm ²	-
Screw Speed	rpm	<100

Note) Back Pressure & 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.

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