

# LUSEP GP4600

Injection Molding, PPS+GF/MF 60%

## Description

General Purpose

## Application

Pump Units, Motor Units, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.89
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.2
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		kg/cm <sup>2</sup>	1,200
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	1 ~ 2
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm <sup>2</sup>	1,800
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm <sup>2</sup>	172,000
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	4.0
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm (Unannealed)		ASTM D648		
	18.6kg		°C	>250
	4.6kg		°C	-
Flammability 0.75mm		UL94	class	
			class	V-0
<b>Electrical</b>				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	-

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

Updated : 8-Jan-13

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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	280~300
	Middle	°C	290~310
	Front	°C	300~320
Nozzle Temperature		°C	310~330
Mold Temperature		°C	120 ~ 150
Back Pressure		kg/cm <sup>2</sup>	-
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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