SolutionPartner

LG Chem

LUSEP FW 2300

Injection Molding

Description

Low wear and friction

Application

Gears, bearings and other siliding friction/wear applications

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.62
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.2
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		MPa	155
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	1~2
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	MPa	210
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	GPa	11
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		J/m	65
Taber abrasion	-	ISO 9352	mg/3,000cycles	75
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	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 molulded specimens and after 48 hours storage at 23℃, 50% relative humidty.

Updated : 12-Apr-16

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100 ~ 130
Drying Time		hrs	2 ~ 4
Minimum Moisture Content		%	0.02
Melt Temperature		℃	300 ~ 320
Cylinder Temperature	Rear	℃	290 ~ 300
	Middle	℃	300 ~ 310
	Front	℃	300 ~ 310
Nozzle Temperature		℃	310 ~ 320
Mold Temperature		℃	130 ~ 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.

Updated : 12-Apr-16