

LUSEP FW 2300

Injection Molding

Description

Low wear and friction

Application

Gears, bearings and other sliding 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 @ Break	5mm/min	ASTM D638	MPa	155
Tensile Elongation, 3.2mm @ Break	5mm/min	ASTM D638	%	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 (Notched)	23°C	ASTM D256	J/m	65
Taber abrasion	-	ISO 9352	mg/3,000cycles	75
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C °C	>260 >260
Flammability 0.75mm		UL94	class class	V-0
Electrical				
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 molulded specimens and 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	100 ~ 130
Drying Time	hrs	2 ~ 4
Minimum Moisture Content	%	0.02
Melt Temperature	°C	300 ~ 320
Cylinder Temperature	Rear	290 ~ 300
	Middle	300 ~ 310
	Front	300 ~ 310
Nozzle Temperature	°C	310 ~ 320
Mold Temperature	°C	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.

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