

# LUSEP GP2400C

Injection Molding, PPS+GF40%

## Description

General Purpose

## Application

Pump Units, Motor Units, etc.

| Properties   | Test Condition  | Test Method | Unit           | Typical Value |
|--|-----------------|-------------|----------------|---------------|
| <b>Physical</b>                                    |                 |             |                |               |
| Specific Gravity                                   |                 | ASTM D792   | -              | 1.65          |
| Molding Shrinkage (Flow), 3.2mm                    |                 | ASTM D955   | %              | 0.1 ~ 0.2     |
| <b>Mechanical</b>                                  |                 |             |                |               |
| Tensile Strength, 3.2mm<br>@ Break                 | 5mm/min         | ASTM D638   | MPa            | 180           |
| Tensile Elongation, 3.2mm<br>@ Break               | 5mm/min         | ASTM D638   | %              | 1 ~ 2         |
| Flexural Strength, 3.2mm                           | 1.3mm/min       | ASTM D790   | MPa            | 255           |
| Flexural Modulus, 3.2mm                            | 1.3mm/min       | ASTM D790   | MPa            | 13,500        |
| IZOD Impact Strength, 3.2mm<br>(Notched)           | 23°C            | ASTM D256   | J/m            | 8.0           |
| <b>Thermal</b>                                     |                 |             |                |               |
| Heat Deflection Temperature, 6.4mm<br>(Unannealed) | 18.6kg<br>4.6kg | ASTM D648   | °C<br>°C       | >250<br>>250  |
| Flammability<br>0.4mm                              |                 | UL94        | class<br>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 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 ~ 120 |
| Drying Time              | hrs                | 2 ~ 4     |
| Minimum Moisture Content | %                  | 0.02      |
| Melt Temperature         | °C                 | 300 ~ 330 |
| Cylinder Temperature     | Rear               | 300       |
|                          | Middle             | 310       |
|                          | Front              | 320       |
| Nozzle Temperature       | °C                 | 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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