

LUSEP GP 2500C

Injection Molding, PPS+GF50%

Description

General Purpose

Application

Automotive Components, Electrical/Electronic Parts, etc

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.75
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.3
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		MPa	190
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	1 ~ 2
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	MPa	280
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	GPa	17
IZOD Impact Strength, 3.2mm (Notched)	23℃	ASTM D256	J/m	90
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	℃	265
Flammability		UL94	class	
0.75mm			class	V-0
Electrical				
Dielectric constant	23℃, 1MHz	ASTM D150	-	4.1
Dissipation Factor	23℃, 1MHz	ASTM D150	-	0.002

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

Updated : 15-Jan-16

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	120 ~ 150
Drying Time		hrs	2 ~ 5
Minimum Moisture Content		%	0.02
Melt Temperature		°C	300 ~ 330
Cylinder Temperature	Rear	°C	290 ~ 300
	Middle	°C	290 ~ 320
	Front	°C	290 ~ 320
Nozzle Temperature		°C	300 ~ 330
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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