

# LUSEP GP4650D

Injection Molding, PPS + GF/MF 65%

## Description

Standard, Low Warpage

## Application

Electric/Electronic Units, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Specific Gravity		ASTM D792	-	1.99
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.2
<b>Mechanical</b>				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		MPa	120
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	1
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	MPa	210
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	GPa	19
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	J/m	55
<b>Thermal</b>				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	265
Flammability		UL94	class	
0.75mm			class	V-0
<b>Electrical</b>				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Volume Resistivity	23 °C	ASTM D257	Ohm·m	10 <sup>13</sup>
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	-

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

Updated : 24-Mar-15

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.

# LUSEP GP4650D

Injection Molding, PPS + GF/MF 65%

## Description

Standard, Low Warpage

## Application

Electric/Electronic Units, etc.

### Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	100 ~ 120
Drying Time		hrs	2 ~ 4
Minimum Moisture Content		%	0.02
Melt Temperature		℃	300 ~ 330
Cylinder Temperature	Rear	℃	300
	Middle	℃	310
	Front	℃	320
Nozzle Temperature		℃	330
Mold Temperature		℃	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.

Updated : 24-Mar-15

The information contained herein, including, but not limited to, data, statements and typical values, are given in good faith. LG Chem makes no warranty or guarantee, expressed or implied, (i) that the result described herein will be obtained under end - use conditions, or (ii) as to the effectiveness or safety of any design incorporating LG Chem materials, products, recommendations or advice. Further, any information contained herein shall not be construed as a part of legally binding offer. Especially, the typical values should be regarded as reference values only and not as binding minimum values. Each user bear full responsibility for making its own determination as to the suitability of LG Chem's materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating LG Chem material or products will be safe and suitable for use under end - use conditions. The data contained herein can be changed without notice as a result of the quality improvement of the products.