

## 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 @ Break	5mm/min	ASTM D638	MPa	120
Tensile Elongation, 3.2mm @ Break	5mm/min	ASTM D638	%	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 0.75mm		UL94	class	V-0
<b>Electrical</b>				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Volume Resistivity	23 °C	ASTM D257	Ohm·m	$10^{13}$
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	-

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

Updated : 24-Mar-15

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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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