

# LUSEP GP4650H

**Injection Molding Grade, PPS+GF/MF65%****Description**

General Purpose

**Application**

Lamp Reflector, Motor Units, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
<b>Physical</b>				
Density		ISO 1183	g/cm <sup>3</sup>	1.96
Molding Shrinkage	2mm	ISO 294-4	%	0.1 ~ 0.2
<b>Mechanical</b>				
Tensile Strength @ Break	23 °C, 5mm/min	ISO 527	MPa	120
Tensile Elongation @ Break	23 °C, 5mm/min	ISO 527	%	< 1
Flexural Strength	2mm/min	ISO 178	MPa	195
Flexural Modulus	2mm/min	ISO 178	MPa	16,500
Charpy Impact Strength, 80*10*4mm (Notched)	23 °C	ISO 180/1A	kJ/m <sup>2</sup>	5.0
<b>Thermal</b>				
Heat Deflection Temperature (Unannealed)	1.8MPa, Flatwise 0.45MPa	ISO 75	°C	>260
Flammability 0.71mm		UL94	class	V-0
<b>Electrical</b>				
Comparative Tracking Index(CTI)	Solution A	UL746	PLC	-
Dielectric Strength, 1mm	23 °C	IEC 60243-1	kV/mm	-

Note) • The property values above are give by Tech Center, LG Chemical Ltd. as a reference only, and are not inteded for spectification purposes.

When pigments are loaded, there might be slight changes in the properties.

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

Updated : 17-Feb-17

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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 Middle Front	300 310 320
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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