

LUSEP HI2302

Injection Molding, PPS+GF30%

Description

High impact

Application

Pump Units, Motor Units, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.50
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	-
Water Absorption	23°C, 24hrs	ASTM D570	%	0.02
Mechanical				
Tensile Strength, 3.2mm @ Break	5mm/min	ASTM D638	MPa	150
Tensile Elongation, 3.2mm @ Break	5mm/min	ASTM D638	%	2 ~ 3
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	MPa	230
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	MPa	9,600
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	J/m	130
Thermal				
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	°C	265
Flammability 0.75mm		UL94	class class	V-0
Electrical				
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 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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