SolutionPartner

LG Chem

LUSEP LF2400C

Injection Molding, PPS+GF40%

Description

Low Flash, High Flow

Application

Connector, Electric/Electronic Unit, etc.

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.64
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.1 ~ 0.2
Water Absorption	23℃, 24hrs	ASTM D570	%	< 0.02
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Break	5mm/min		MPa	160
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	1~2
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	MPa	220
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	MPa	13,500
IZOD Impact Strength, 3.2mm		ASTM D256		
(Notched)	23℃		J/m	65
	-30℃		J/m	-
Rockwell Hardness	R-Scale	ASTM D785	-	-
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
(Unannealed)	18.6kg		℃	265
	4.6kg		℃	
Flammability		UL94	class	
0.75mm			class	V-0
Electrical				
Comparative Tracking Index(CTI)	Solution A	IEC 60112	Volts	-
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm	-

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

Updated : 29-Apr-16

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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^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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