

SolutionPartner


LUCEL GC210

Injection molding, POM+GF10%

Description

High rigidity

Application

Casings of Pump and Pivot Bearings

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.48
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.6 ~ 1.1
Melt flow rate		ASTM D1238	g/10min	15
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@Yield	10 mm/min		kg/cm ²	1,000
Tensile Elongation, 3.2mm		ASTM D638		
@Break	10 mm/min		%	5
Flexural Strength, 6.4mm	2.8 mm/min	ASTM D790	kg/cm ²	1,300
Flexural Modulus, 6.4mm	2.8 mm/min	ASTM D790	kg/cm ²	50,000
Izod Impact Strength, 6.4mm		ASTM D256		
(Notched)	23 °C		kg·cm/cm	5.0
Rockwell Hardness	R-Scale	ASTM D785	-	83
Thermal				
Heat Deflection Temperature, 6.4mm		ASTM D648		
	18.6 kg		°C	160
	4.6 kgf		°C	165
Flammability		UL94		
	0.75 mm		class	HB
	1.5 mm		class	HB
	2.5 mm		class	
	3.0 mm		class	HB
Electrical				
Dissipation factor		ASTM D150		
	1 MHz			
Surface Resistivity		ASTM D257	Ohm	1 x 10 ¹⁴
Volume Resistivity	23 °C	ASTM D257	Ohm·cm	1 x 10 ¹⁶
Dielectric Strength	23 °C	ASTM D149	kV/mm	

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
[Pre-drying]			
Drying Temperature		°C	90 ~ 110
Drying Time		hrs	2 ~ 3
Maximum Moisture Content		%	0.1
[Temperature]			
Mold temperature		°C	60 ~ 100
Cylinder Temperature	Rear		180 ~ 200
	Middle	°C	190 ~ 210
	Front	°C	200 ~ 220
Nozzle Temperature		°C	200 ~ 220
Back Pressure		bar	0 ~ 41
Screw Speed		mm/s	40 ~ 75

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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