

Lucel® GC225

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

LUCEL GC-225 improves rigidity and conductivity by compounding actal with glass fiber. Users have various options to select grades appropriate for their application.

General Information			
UL YellowCard	E67171-248287		
Filler / Reinforcement	Glass Fiber,25% Filler by Weight		
Features	Fatigue Resistant		
	Good Abrasion Resistance		
	Good Chemical Resistance		
	Good Creep Resistance		
	Good Dimensional Stability		
	Good Moldability		
	Good Thermal Stability		
	High Strength		
Uses	Pump Parts		
UL File Number	E67171		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.59	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.45 to 0.85	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (M-Scale)	85		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	128	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus ²	7900	MPa	ASTM D790
Flexural Strength ³ (Yield)	197	MPa	ASTM D790
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	40.0	mg	ASTM D1044
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	90	J/m	ASTM D256
Unnotched Izod Impact	640	J/m	ASTM D256
Reverse Notch Izod Impact	700	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648

0.45 MPa, Annealed, 6.35 mm	165	°C	
1.8 MPa, Annealed, 6.35 mm	160	°C	
CLTE - Flow (20 to 80°C)	4.0E-5	cm/cm/°C	ASTM D696
RTI Elec (0.750 mm)	50.0	°C	UL 746
RTI Imp (0.750 mm)	50.0	°C	UL 746
RTI Str (0.750 mm)	50.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+14	ohms	ASTM D257
Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Dielectric Strength	23	kV/mm	ASTM D149
Arc Resistance	125	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm, ALL)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	3.0 to 6.0	hr	
Rear Temperature	170 to 190	°C	
Middle Temperature	190 to 210	°C	
Front Temperature	200 to 220	°C	
Nozzle Temperature	200 to 220	°C	
Processing (Melt) Temp	200 to 225	°C	
Melt Temperature (Aim)	210	°C	
Mold Temperature	60.0 to 100	°C	
Injection Pressure	78.3 to 127	MPa	
Back Pressure	0.00 to 3.92	MPa	
Screw Speed	40 to 75	rpm	
NOTE			
1.	50 mm/min		
2.	15 mm/min		
3.	15 mm/min		

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