

Lumiloy® GP1000D

Polyphenylene Ether + PS

LG Chem Ltd.

Message:

Injection Molding Grade, General Purpose

Description

High Impact Strength

Application

Electric and Electronic Parts

General Information			
Features	General Purpose		
	High Impact Resistance		
Uses	Electrical/Electronic Applications		
	General Purpose		
Processing Method		Injection Molding	
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (280°C/5.0 kg)	7.5	g/10 min	ASTM D1238
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	57.9	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	40	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	2280	MPa	ASTM D790
Flexural Strength ⁴ (Break, 3.20 mm)	96.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	220	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	128	°C	
1.8 MPa, Unannealed, 6.40 mm	134	°C	
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	> 0.030	%	
Rear Temperature	260 to 300	°C	
Middle Temperature	270 to 310	°C	
Front Temperature	270 to 310	°C	
Nozzle Temperature	270 to 310	°C	
Processing (Melt) Temp	280 to 320	°C	

Mold Temperature	70.0 to 110	°C
NOTE		
1.	50 mm/min	
2.	50 mm/min	
3.	10 mm/min	
4.	10 mm/min	

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