

LUMILOY GP2200K

Injection Molding Grade, General Purpose

Description

GF 20% Reinforced
NSF Certified for KA02 and E2035
High Flow, High Impact Strength
Hydrolytic Stability

Application

Electric and Electronic parts
Part for Water contact
Water pump Housing or Impellers

Properties	Test Condition	Test Method	Unit	Typical Property
Physical				
Specific Gravity		ASTM D792	-	1.18
Mold Shrinkage (flow)		LG Method	%	0.3 ~ 0.5
Water Absorption	23 °C, 24hrs	ASTM D570	%	0.06
Melt Flow Rate	280 °C/5kg	ASTM D1238	g/10min	18
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	5mm/min		kg/cm ²	1000
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	5mm/min		%	2
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	1,500
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	45,000
Rockwell Hardness	L-scale	ASTM D785	-	112
IZOD Impact Strength, 3.2mm (Notched)	23 °C	ASTM D256	kg·cm/cm	6.0
Thermal				
Heat Deflection Temperature, 3.2mm (Unannealed)	18.6kg	ASTM D648	°C	135
Flammability		UL94		
0.8mm			class	HB
1.6mm			class	HB
2.5mm			class	HB
3.2mm			class	HB

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 17-Aug-15

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	80 ~ 100
Drying Time	hrs	4 ~ 5
Maximum Moisture Content	%	0.02
Melt Temperature	°C	280 ~ 320
Cylinder Temperature	Rear	°C 260 ~ 300
	Middle	°C 270 ~ 310
	Front	°C 270 ~ 310
Nozzle Temperature	°C	270 ~ 310
Mold Temperature	°C	70 ~ 110

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