

Lucon® PN9009

Polyphenylene Sulfide

LG Chem Ltd.

Message:

Description

High Thermal Conductivity, Chemical Resistance, High Heat Resistance

Application

Electrical or Electronic Parts (Heat Sink, LED), Motor Housing

General Information			
Filler / Reinforcement	Mineral		
Features	Good Chemical Resistance		
	High Heat Resistance		
	Thermally Conductive		
Uses	Electric Motor Housings		
	Electrical/Electronic Applications		
	LEDs		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.95	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (320°C/5.0 kg)	40	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	0.40 to 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	49.0	MPa	ASTM D638
Flexural Modulus ² (6.40 mm)	13700	MPa	ASTM D790
Flexural Strength ³ (Yield, 6.40 mm)	88.3	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	20	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm)	260	°C	ASTM D648
Thermal Conductivity	2.5	W/m/K	ASTM C177
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+8	ohms	IEC 60093
Volume Resistivity (23°C)	1.0E+10	ohms · cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	120 to 140	°C	
Drying Time	3.0 to 5.0	hr	
Suggested Max Moisture	< 0.010	%	

Rear Temperature	280 to 310	°C
Middle Temperature	310 to 320	°C
Front Temperature	320 to 325	°C
Nozzle Temperature	310 to 330	°C
Processing (Melt) Temp	330	°C
Mold Temperature	130 to 150	°C
Back Pressure	0.981 to 3.92	MPa
Screw Speed	40 to 80	rpm

NOTE

- | | |
|----|------------|
| 1. | 5.0 mm/min |
| 2. | 1.0 mm/min |
| 3. | 1.0 mm/min |

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