

Lucel® GC240

Acetal (POM) Copolymer

LG Chem Ltd.

Message:

LUCEL GC-240 improves rigidity and conductivity by compounding actal with glass fiber. Users have various options to select grades appropriate for their application.

General Information			
Filler / Reinforcement	Glass Fiber		
Features	High Elasticity		
	High Strength		
Uses	Pump Parts		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.72	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow	0.30 to 0.70	%	
Across Flow	0.30	%	
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	87		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield)	148	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	3.0	%	ASTM D638
Flexural Modulus ² (23°C)	11800	MPa	ASTM D790
Flexural Strength ³ (Yield)	276	MPa	ASTM D790
Taber Abrasion Resistance (1000 Cycles, 1000 g, CS-17 Wheel)	46.0	mg	ASTM D1044
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	120	J/m	ASTM D256
Reverse Notch Izod Impact (23°C)	900	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	165	°C	
Melting Temperature	165	°C	
CLTE - Flow (20 to 80°C)	3.0E-5	cm/cm/°C	ASTM D696
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	25	kV/mm	ASTM D149
Arc Resistance	135	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.734 mm)	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	
Melt Temperature (Aim)	210	°C	
Mold Temperature	60.0 to 100	°C	
Injection Pressure	68.6 to 118	MPa	
Holding Pressure	39.2 to 83.4	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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