

GPPS 25SPI

Description

25SPI is a GPPS product for injection molding, designed to have high transparency and strength.

Key Features

High Transparency, Electrical Properties, Colorability, High Strength

Application

Refrigerator Shelf, Electrical/Electronic Products, Miscellaneous Goods

Properties	Condition	Method	Unit	GPPS 25SPI
Physical				
Specific Gravity	23°C	ASTM D792		1.05
Mold Shrinkage	23°C, 3.2mm	ASTM D955	%	0.4 ~ 0.8
Melt Flow Index	200°C, 5kg	ASTM D1238	g/10min	3.2
Melt Flow Index	220°C, 10kg	ASTM D1238	g/10min	38
Melt Flow Index	230°C, 3.8kg	ASTM D1238	g/10min	9
Mechanical				
Tensile Strength at Yield	23°C, 50mm/min, 3.2mm	ASTM D638	kg/cm ²	510
Tensile Elongation at Break	23°C, 50mm/min, 3.2mm	ASTM D638	%	6
Tensile Modulus	23°C, 1mm/min, 3.2mm	ASTM D638	kg/cm ²	29400
Flexural Strength	23°C, 10mm/min, 6.4mm	ASTM D790	kg/cm ²	960
Flexural Modulus	23°C, 10mm/min, 6.4mm	ASTM D790	kg/cm ²	33300
Izod Impact Strength	Notched, 6.4mm, 23°C	ASTM D256	kg·cm/cm	1
Rockwell Hardness	R-Scale	ASTM D785		121
Thermal				
Heat Deflection Temperature	Edgewise, 18.6kg, 6.4mm, Unannealed	ASTM D648	°C	88
Vicat Softening Temperature	5kg, 50°C/h	ASTM D1525	°C	92

Note

Typical values can be used only for the purpose of selecting material, and there can be variation within normal tolerances for various colors.

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

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

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Processing Guide (Injection Molding)

Processing Parameters	Unit	Value
Drying Temperature	°C	70 ~ 80
Drying Time	hrs	3 ~ 4
Injection Temperature	°C	190 ~ 220
Mold Temperature	°C	40 ~ 80
Screw Speed	rpm	30 ~ 60

Note

Injection Temperature & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.