

Lumid® HI5006A(W)

Polyamide 6 + ABS

LG Chem Ltd.

Message:

Description

High Impact, Good Dimensional Stability

Application

Pipe Fitting , Electrical and Electronic parts

General Information			
UL YellowCard	E67171-101743135		
Features	Good Dimensional Stability		
	Good Impact Resistance		
Uses	Electrical/Electronic Applications		
	Fittings		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.06	g/cm ³	ASTM D792
Molding Shrinkage - Flow (23°C, 3.20 mm)	0.80 to 1.2	%	ASTM D955
Water Absorption (24 hr)	0.70	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	44.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	100	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1570	MPa	ASTM D790
Flexural Strength ⁴ (6.40 mm)	59.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	690	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	110	°C	
1.8 MPa, Unannealed, 6.40 mm	80.0	°C	
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	8.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	26	kV/mm	ASTM D149
Dielectric Constant (23°C, 1 MHz)	2.90		ASTM D150
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 90.0	°C	

Drying Time	4.0 to 5.0	hr
Rear Temperature	235 to 250	°C
Middle Temperature	240 to 260	°C
Front Temperature	240 to 260	°C
Nozzle Temperature	250 to 265	°C
Processing (Melt) Temp	250 to 265	°C
Mold Temperature	80.0 to 100	°C

NOTE

- | | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 3.0 mm/min |
| 4. | 3.0 mm/min |

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

