

Lumid® GP3400B(W)

Polyamide 66

LG Chem Ltd.

Message:

Description
General Purpose
Applications
Automotive(Engine Cover)

General Information			
Uses	Automotive Applications		
	Automotive Under the Hood		
	General Purpose		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.60 to 0.80	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	83.4	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	5.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	6860	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	127	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	34	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	240	°C	
1.8 MPa, Unannealed, 6.40 mm	210	°C	
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	4.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength (1.00 mm)	20	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.090	%	

Rear Temperature	265 to 275	°C
Middle Temperature	270 to 280	°C
Front Temperature	270 to 285	°C
Nozzle Temperature	270 to 295	°C
Processing (Melt) Temp	270 to 290	°C
Mold Temperature	80.0 to 110	°C
Back Pressure ⁵	0.981 to 2.94	MPa
Screw Speed	60 to 150	rpm

NOTE

- | | |
|----|----------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | Hydraulic Type |

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