

Lumid® HI2152A(W)

Polyamide 6
LG Chem Ltd.

Message:

Description
High Impact
Applications
Automotive Parts

General Information			
Features	High Impact Resistance		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.50 to 1.0	%	ASTM D955
Water Absorption (24 hr)	1.2	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	98.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	4.5	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	3920	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	137	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 6.40 mm	59	J/m	
23°C, 6.40 mm	140	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	200	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	3.6E-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)	21	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.50		ASTM D150
Arc Resistance	180	sec	ASTM D495
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	

Suggested Max Moisture	0.10	%
Rear Temperature	250 to 270	°C
Middle Temperature	260 to 285	°C
Front Temperature	260 to 290	°C
Nozzle Temperature	260 to 290	°C
Processing (Melt) Temp	260 to 280	°C
Mold Temperature	80.0 to 100	°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. | 2.8 mm/min |
| 4. | 2.0 mm/min |
| 5. | Hydraulic Type |

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