

Lumid® GP3400A(W)

Polyamide 6
LG Chem Ltd.

Message:

Description
General Purpose
Applications
E&E(Rice Cooker Housing)

General Information			
UL YellowCard	E248280-100040913	E302314-530080	E67171-248540
Features	General Purpose		
Uses	Appliances		
	Electrical/Electronic Applications		
	Housings		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.49	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.80	%	ASTM D955
Water Absorption (24 hr)	1.0	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		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)	3.0	%	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)	69	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	210	°C	
1.8 MPa, Unannealed, 6.40 mm	180	°C	
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	5.1E-5	cm/cm/°C	ASTM D696
RTI Elec			UL 746
1.50 mm	120	°C	
3.00 mm	120	°C	
RTI Imp			UL 746
1.50 mm	105	°C	

3.00 mm	105	°C	
RTI Str			UL 746
1.50 mm	120	°C	
3.00 mm	120	°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+17	ohms·cm	ASTM D257
Dielectric Strength (1.00 mm)	22	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.00		ASTM D150
Arc Resistance	185	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
0.750 mm	HB		
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	
Rear Temperature	250 to 270	°C	
Middle Temperature	255 to 275	°C	
Front Temperature	255 to 275	°C	
Nozzle Temperature	260 to 280	°C	
Processing (Melt) Temp	260 to 280	°C	
Mold Temperature	60.0 to 80.0	°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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