

Lumid® HI5003A

Polyamide + Polyolefin

LG Chem Ltd.

Message:

Description

High Impact, High Flow, Good Paintability

Application

Automotive Exterior Parts

General Information			
Features	High Flow		
	High Impact Resistance		
	Paintable		
Uses	Automotive Exterior Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/2.16 kg)	3.5	g/10 min	ASTM D1238
Molding Shrinkage - Flow (3.20 mm)	1.4 to 1.5	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.50	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	51.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	50	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2060	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	70.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
-30°C, 6.40 mm	120	J/m	
23°C, 6.40 mm	450	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load ⁵ (0.45 MPa, Unannealed, 6.40 mm)	162	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 90.0	°C	
Drying Time	4.0 to 5.0	hr	
Rear Temperature	240 to 260	°C	
Middle Temperature	240 to 260	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	240 to 270	°C	
Processing (Melt) Temp	230 to 250	°C	

Mold Temperature	40.0 to 80.0	°C
Back Pressure	29.4 to 58.8	MPa
Screw Speed	30 to 70	rpm

NOTE

- | | |
|----|------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 3.0 mm/min |
| 4. | 3.0 mm/min |
| 5. | 4.6kg |

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