

Lumid® HI5063A(W)

Polyamide 6 + ABS

LG Chem Ltd.

Message:

Description
High Impact
Application
Electric/Electronic Components(Shaver Die)

General Information			
UL YellowCard	E67171-100743572	E248280-101162023	
Features	High Impact Resistance		
Uses	Electrical/Electronic Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.50 to 1.0	%	ASTM D955
Water Absorption (24 hr)	0.60	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	46.1	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	60	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1960	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	60.8	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	90.0	°C	ASTM D648
CLTE - Flow	6.5E-5 to 1.0E-4	cm/cm/°C	ASTM D696
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
0.750 mm	HB		
1.50 mm	HB		
3.00 mm	HB		
Injection	Nominal Value	Unit	
Drying Temperature	70.0 to 90.0	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.12	%	
Rear Temperature	245 to 260	°C	
Middle Temperature	250 to 270	°C	
Front Temperature	250 to 270	°C	

Nozzle Temperature	260 to 275	°C
Processing (Melt) Temp	260 to 275	°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. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 2.8 mm/min |
| 4. | 2.8 mm/min |
| 5. | Hydraulic Type |

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