

Lumid® HI2302A(W)

Polyamide 6

LG Chem Ltd.

Message:

Description

High Impact

Applications

Automotive Parts

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	High Impact Resistance		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.34	g/cm ³	ASTM D792
Molding Shrinkage - Flow (23°C, 3.20 mm)	0.40 to 0.90	%	ASTM D955
Water Absorption (Equilibrium)	1.0	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	152	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	4.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	7850	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	235	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	220	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	205	°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 (23°C)	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	21	kV/mm	ASTM D149
Dielectric Constant (23°C, 1 MHz)	3.50		ASTM D150
Arc Resistance ⁵	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	0.12	%	

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 290	°C
Mold Temperature	80.0 to 100	°C
Back Pressure ⁶	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.	23°C
6.	Hydraulic Type

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