

Lumid® EG2309B(W)

Polyamide 66

LG Chem Ltd.

Message:

Description

Chemical Resistance(CaCl₂, Ethylene Glycol)

Application

Radiator Tank, Intercooler Tank

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Good Chemical Resistance		
Uses	Tanks		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.90	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 6.40 mm)	177	MPa	ASTM D638
Tensile Elongation ² (Break, 6.40 mm)	4.0	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	8140	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	255	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	110	J/m	
23°C, 6.40 mm	98	J/m	
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	260	°C	
1.8 MPa, Unannealed, 6.40 mm	250	°C	
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	3.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0E+14	ohms · cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	25	kV/mm	ASTM D149
Dielectric Constant (23°C, 1 MHz)	4.00		ASTM D150
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	

Drying Time	4.0 to 5.0	hr
Suggested Max Moisture	< 0.080	%
Rear Temperature	260 to 270	°C
Middle Temperature	270 to 285	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	270 to 295	°C
Processing (Melt) Temp	270 to 295	°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. | 2.8 mm/min |
| 5. | Hydraulic Type |

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