

Lumid® GP1300A(W)

Polyamide 6
LG Chem Ltd.

Message:

Description
High Viscosity
Application
Automotive Parts

General Information			
Features	High Viscosity		
Uses	Automotive Applications		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.0 to 1.4	%	ASTM D955
Water Absorption (Equilibrium)	1.7	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	76.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	170	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2550	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	49	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm ⁵	160	°C	
0.45 MPa, Unannealed, 6.40 mm ⁶	60.0	°C	
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	8.0E-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)	19	kV/mm	ASTM D149
Dielectric Constant (23°C, 1 MHz)	3.50		ASTM D150
Arc Resistance ⁷	195	sec	ASTM D495
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	
Rear Temperature	225 to 245	°C	

Middle Temperature	230 to 260	°C
Front Temperature	240 to 270	°C
Nozzle Temperature	240 to 270	°C
Processing (Melt) Temp	240 to 270	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure ⁸	0.490 to 1.96	MPa
Screw Speed	60 to 200	rpm

NOTE

1.	50 mm/min
2.	50 mm/min
3.	3.0 mm/min
4.	3.0 mm/min
5.	4.6kg
6.	18.6kg
7.	23°C
8.	Hydraulic Type

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