Lumid® HM2604A(W)

Polyamide 6

LG Chem Ltd.

Message:

Lumid® HM2604A(W) is a Polyamide 6 (Nylon 6) material filled with 60% glass fiber. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding. Primary attribute of Lumid® HM2604A(W): High Stiffness.

General Information			
Filler / Reinforcement	Glass Fiber,60% Filler by Weight		
Features	High Stiffness		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.69	g/cm³	ASTM D792
Molding Shrinkage - Flow (23°C, 3.20 mm)	0.20 to 0.50	%	ASTM D955
Water Absorption (Saturation)	0.70	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	130		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (Break, 3.20 mm)	206	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	2.0	%	ASTM D638
Flexural Modulus [3] (3.20 mm)	15700	MPa	ASTM D790
Flexural Strength [4] (3.20 mm)	304	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 3.20 mm)	160	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+17	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	180	sec	ASTM D495
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	
Rear Temperature	250 to 270	°C	
Middle Temperature	260 to 290	°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

NOTE	
1.	5.0 mm/min
2.	50 mm/min
3.	1.3 mm/min
4.	1.3 mm/min

Recommended distributors for this material

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