

Lumid® LW4203A(W)

Polyamide 6 + ABS

LG Chem Ltd.

Message:

Description
Low Warpage
Applications
Automotive Parts(Engine Cover)

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
	Mineral,20% Filler by Weight		
Features	Low Warpage		
Uses	Automotive Applications		
	Automotive Under the Hood		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Molding Shrinkage - Flow (23°C, 3.20 mm)	0.70 to 1.2	%	ASTM D955
Water Absorption (Equilibrium)	1.2	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	88.3	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	6.0	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	3920	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	137	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	44	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	185	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	4.6E-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)	3.00		ASTM D150
Arc Resistance ⁵	130	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	235 to 250	°C
Middle Temperature	240 to 265	°C
Front Temperature	240 to 265	°C
Nozzle Temperature	250 to 275	°C
Processing (Melt) Temp	250 to 275	°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. | 2.8 mm/min |
| 4. | 2.8 mm/min |
| 5. | 23°C |
| 6. | Hydraulic Type |

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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