Lumid® HI3232A(W)

Polyamide 6

LG Chem Ltd.

Message:

Description
High Impact
Applications
Automotive Parts

General Information			
Filler / Reinforcement	Glass Fiber,23% Filler by Weight		
Features	High Impact Resistance		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.32	g/cm³	ASTM D792
Molding Shrinkage - Flow (23°C, 3.20 mm)	0.90 to 1.3	%	ASTM D955
Water Absorption (Equilibrium)	1.0	%	ASTM D570
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	113		ASTM D785
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Strength [1] (Break, 3.20 mm)	53.9	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	12	%	ASTM D638
Flexural Modulus [3] (6.40 mm)	2750	MPa	ASTM D790
Flexural Strength [4] (Yield, 6.40 mm)	98.1	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			ASTM D256
-30°C, 3.20 mm	69	J/m	
23°C, 3.20 mm	98	J/m	
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm)	190	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	5.5E-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)	22	kV/mm	ASTM D149
Dielectric Constant (23°C, 1 MHz)	4.00		ASTM D150
Arc Resistance [5]	185	sec	ASTM D495
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0 to 100	°C	

Drying Time	4.0 to 5.0	hr
Rear Temperature	240 to 270	°C
Middle Temperature	245 to 275	°C
Front Temperature	245 to 275	°C
Nozzle Temperature	250 to 280	°C
Processing (Melt) Temp	250 to 280	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure	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

Recommended distributors for this material

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