

Lumid® GP1300AP

Polyamide 6
LG Chem Ltd.

Message:

Description
Plasticized
Applications
Automotive Parts

General Information			
Features	Plasticized		
Uses	Automotive Applications		
Processing Method	Injection Molding		
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 (23°C, 24 hr)	1.7	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	105		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	49.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	250	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1180	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	44.1	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	88	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	150	°C	
1.8 MPa, Unannealed, 6.40 mm	50.0	°C	
Peak Melting Temperature	212	°C	ASTM D3418
CLTE - Flow	8.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength (1.00 mm)	19	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	2.80		ASTM D150
Arc Resistance	195	sec	ASTM D495
Injection	Nominal Value	Unit	
Drying Temperature	65.0	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.10	%	

Rear Temperature	215 to 245	°C
Middle Temperature	215 to 245	°C
Front Temperature	220 to 250	°C
Nozzle Temperature	220 to 250	°C
Processing (Melt) Temp	215 to 250	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure ⁵	0.490 to 1.96	MPa
Screw Speed	60 to 200	rpm

NOTE

- | | |
|----|----------------|
| 1. | 50 mm/min |
| 2. | 50 mm/min |
| 3. | 2.8 mm/min |
| 4. | 2.8 mm/min |
| 5. | Hydraulic Type |

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