

Lumid® GP2200A(W)

Polyamide 6
LG Chem Ltd.

Message:

Description
General Purpose
Application
HMID, SLMP B, Holder

General Information			
UL YellowCard	E67171-102080608		
Features	General Purpose		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.60 to 1.0	%	ASTM D955
Water Absorption (23°C, 24 hr)	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 (Yield, 3.20 mm)	147	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	4.0	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	6670	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	216	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 (1.8 MPa, Unannealed, 6.40 mm)	205	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	4.5E-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)	20	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.80		ASTM D150
Arc Resistance	150	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	HB		UL 94
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 255	°C
Middle Temperature	240 to 270	°C
Front Temperature	240 to 270	°C
Nozzle Temperature	250 to 280	°C
Processing (Melt) Temp	250 to 280	°C
Mold Temperature	80.0 to 100	°C
Back Pressure ⁵	0.981 to 2.94	MPa
Screw Speed	60 to 150	rpm

NOTE

- | | |
|----|----------------|
| 1. | 5.0 mm/min |
| 2. | 5.0 mm/min |
| 3. | 3.0 mm/min |
| 4. | 3.0 mm/min |
| 5. | Hydraulic Type |

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