

Lumid® LW4303B(W)

Polyamide 6 + ABS

LG Chem Ltd.

Message:

Description
Low Warpage
Application
Automotive Parts

General Information			
Features	Low Warpage		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.50 to 1.1	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	118	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	4.5	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	5880	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	186	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	49	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	235	°C	ASTM D648
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	4.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength (1.00 mm)	21	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	270 to 285	°C	
Middle Temperature	275 to 290	°C	
Front Temperature	280 to 290	°C	

Nozzle Temperature	280 to 295	°C
Processing (Melt) Temp	270 to 295	°C
Mold Temperature	80.0 to 110	°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. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | Hydraulic Type |

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