

Lumid® GP3200B(W)

Polyamide 66

LG Chem Ltd.

Message:

Lumid®GP3200B(W) is a polyamide 66 (nylon 66) material, which contains a 20% mineral filler. This product is available in North America, Latin America, Europe or Asia Pacific. The processing method is injection molding.

Lumid®The typical application field of GP3200B(W) is: automobile industry

General Information			
Filler / Reinforcement	Mineral filler, 20% filler by weight		
Features	General		
Uses	Application in Automobile Field		
	General		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.0 - 1.2	%	ASTM D955
Water Absorption (23°C, 24 hr)	1.0	%	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)	79.4	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	8.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	3920	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	118	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	39	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	230	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	150	°C	ASTM D648
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	6.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	20	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	4.0 - 5.0	hr	
Rear Temperature	265 - 275	°C	

Middle Temperature	270 - 280	°C
Front Temperature	270 - 285	°C
Nozzle Temperature	270 - 295	°C
Processing (Melt) Temp	270 - 290	°C
Mold Temperature	80.0 - 110	°C
Back Pressure	29.4 - 58.8	MPa
Screw Speed	30 - 60	rpm

Injection instructions

Minimum Moisture Content: 0.01%

NOTE

1.	5.0 mm/min
2.	5.0 mm/min
3.	1.3 mm/min
4.	1.3 mm/min

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