

Lumid® HI1202B(W)

Polyamide 66

LG Chem Ltd.

Message:

Description
High Impact
Applications
Automotive(Covers)

General Information			
Features	High Impact Resistance		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.7 to 2.0	%	ASTM D955
Water Absorption (23°C, 24 hr)	1.1	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	52.0	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	45	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1810	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	68.6	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	830	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	200	°C	
1.8 MPa, Unannealed, 6.40 mm	65.0	°C	
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	7.0E-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)	24	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.00		ASTM D150
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	260 to 275	°C	

Middle Temperature	265 to 275	°C
Front Temperature	270 to 280	°C
Nozzle Temperature	270 to 280	°C
Processing (Melt) Temp	270 to 280	°C
Mold Temperature	60.0 to 90.0	°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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