

Lumid® GP2251AF

Polyamide 6
LG Chem Ltd.

Message:

Description
Flame Retardant
Application
IT/OA (Micro Switch)

General Information			
UL YellowCard	E302314-530071		
Features	Flame Retardant		
Uses	Switches		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.90	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.70	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	121		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Break, 3.20 mm)	147	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	4.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	8630	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	226	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	78	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	195	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	4.1E-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)	21	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.80		ASTM D150
Arc Resistance	90.0	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	V-0		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	230 to 260	°C
Middle Temperature	240 to 270	°C
Front Temperature	240 to 270	°C
Nozzle Temperature	240 to 270	°C
Processing (Melt) Temp	240 to 265	°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. | 1.3 mm/min |
| 4. | 1.3 mm/min |
| 5. | Hydraulic Type |

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