

Lumid® HI1102B(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	1.10	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.2 to 1.6	%	ASTM D955
Water Absorption (23°C, 24 hr)	1.3	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	113		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	59.8	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	35	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	1960	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	78.5	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	200	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	225	°C	
1.8 MPa, Unannealed, 6.40 mm	70.0	°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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