

Lumid® GP2500A(W)

Polyamide 6
LG Chem Ltd.

Message:

Description
General Purpose
Applications
Automotive(Gear Shift Housing)

General Information			
UL YellowCard	E67171-102080608		
Features	General Purpose		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.20 to 0.50	%	ASTM D955
Water Absorption (24 hr)	0.80	%	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)	221	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	2.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	13700	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	324	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	150	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	210	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	2.8E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+17	ohms · cm	ASTM D257
Dielectric Strength (1.00 mm)	25	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.80		ASTM D150
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.750 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	

Suggested Max Moisture	0.10	%
Rear Temperature	250 to 270	°C
Middle Temperature	260 to 285	°C
Front Temperature	260 to 290	°C
Nozzle Temperature	260 to 290	°C
Processing (Melt) Temp	260 to 290	°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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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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