

Lumid® GP2330BL

Polyamide 66

LG Chem Ltd.

Message:

Description
General Purpose
Applications
Automotive(Radiator Tank, Reservoir)

General Information			
Features	General Purpose		
Uses	Automotive Applications		
	Automotive Under the Hood		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.90	%	ASTM D955
Water Absorption (24 hr)	0.70	%	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)	191	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	3.0	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	9320	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 3.20 mm)	279	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	130	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	260	°C	
1.8 MPa, Unannealed, 6.40 mm	250	°C	
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	3.0E-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)	25	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	4.00		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 270	°C
Middle Temperature	270 to 285	°C
Front Temperature	270 to 290	°C
Nozzle Temperature	270 to 295	°C
Processing (Melt) Temp	270 to 295	°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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