

Lumid® HI1102A(W)

Polyamide 6

LG Chem Ltd.

Message:

Description

High Impact

Applications

H/Lamp Screw Mounting

General Information			
Features	High Impact Resistance		
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 (Equilibrium)	1.4	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	114		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	56.9	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	45	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2260	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	80.4	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	340	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (0.45 MPa, Unannealed, 6.40 mm)	150	°C	ASTM D648
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	1.0E-4	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0E+15	ohms · cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	19	kV/mm	ASTM D149
Dielectric Constant (23°C, 1 MHz)	2.80		ASTM D150
Arc Resistance ⁵	195	sec	ASTM D495
Injection	Nominal Value	Unit	
Drying Temperature	80.0 to 100	°C	
Drying Time	4.0 to 5.0	hr	
Rear Temperature	230 to 260	°C	
Middle Temperature	240 to 270	°C	
Front Temperature	250 to 280	°C	

Nozzle Temperature	250 to 280	°C
Processing (Melt) Temp	250 to 280	°C
Mold Temperature	60.0 to 80.0	°C
Back Pressure ⁶	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. | 23°C |
| 6. | Hydraulic Type |

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