

Lumid® GP1200A(W)

Polyamide 6
LG Chem Ltd.

Message:

Description
Medium Viscosity
Applications
Industrial Material, Sport Parts

General Information			
Features	Medium Viscosity		
Uses	Industrial Applications		
	Sporting Goods		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.0 to 1.4	%	ASTM D955
Water Absorption (23°C, 24 hr)	1.7	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹ (Yield, 3.20 mm)	73.5	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	130	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2650	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	108	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 6.40 mm)	49	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 6.40 mm	170	°C	
1.8 MPa, Unannealed, 6.40 mm	60.0	°C	
Peak Melting Temperature	220	°C	ASTM D3418
CLTE - Flow	8.0E-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)	19	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.50		ASTM D150
Arc Resistance	195	sec	ASTM D495
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	225 to 245	°C
Middle Temperature	230 to 260	°C
Front Temperature	240 to 270	°C
Nozzle Temperature	240 to 270	°C
Processing (Melt) Temp	240 to 270	°C
Mold Temperature	60.0 to 80.0	°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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