Lumid® GP2309A(W)

Polyamide 6

LG Chem Ltd.

Message:

Description
General Purpose
Applications
Automotive(Cooling Fan)

General Information			
Features	General Purpose		
Uses	Automotive Applications		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.35	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.90	%	ASTM D955
Water Absorption (24 hr)	1.1	%	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)	162	MPa	ASTM D638
Tensile Elongation [2] (Break, 3.20 mm)	4.5	%	ASTM D638
Flexural Modulus [3] (6.40 mm)	8830	MPa	ASTM D790
Flexural Strength [4] (Yield, 6.40 mm)	255	MPa	ASTM D790
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact (23°C, 6.40 mm)	130	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	3.5E-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)	20	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.80		ASTM D150
Arc Resistance	130	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	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.	2.8 mm/min
4.	2.8 mm/min
5.	Hydraulic Type

Recommended distributors for this material

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