

Lumid® SG4389B

Polyamide 66

LG Chem Ltd.

Message:

Lumid®SG4389B is a polyamide 66 (nylon 66) material, which contains 38% glass fiber reinforced materials and 38% mineral fillers. This product is available in North America, Latin America, Europe or Asia Pacific. The processing method is injection molding. Lumid®The main characteristics of the SG4389B are: beautiful.
Lumid®The typical application fields of SG4389B are: automobile industry

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 38% filler by weight		
	Mineral filler, 38% filler by weight		
Features	Excellent appearance		
Uses	Application in Automobile Field		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.43	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.30 - 0.90	%	ASTM D955
Water Absorption (23°C, 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)	127	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	3.4	%	ASTM D638
Flexural Modulus ³ (3.20 mm)	6670	MPa	ASTM D790
Flexural Strength ⁴ (3.20 mm)	172	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			ASTM D256
23°C, 3.20 mm	63	J/m	ASTM D256
23°C, 6.40 mm	65	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 6.40 mm)	238	°C	ASTM D648
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	4.0E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	1.0E+16	ohms · cm	ASTM D257
Dielectric Strength (23°C, 1.00 mm)	21	kV/mm	ASTM D149
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	

Drying Time	4.0 - 5.0	hr
Rear Temperature	260 - 270	°C
Middle Temperature	270 - 280	°C
Front Temperature	280 - 290	°C
Nozzle Temperature	280 - 290	°C
Processing (Melt) Temp	275 - 285	°C
Mold Temperature	80.0 - 110	°C
Back Pressure	29.4 - 58.8	MPa
Screw Speed	30 - 60	rpm

Injection instructions

Minimum Moisture Content: 0.06%

NOTE

1.	5.0 mm/min
2.	5.0 mm/min
3.	1.3 mm/min
4.	1.3 mm/min

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