

Lumid® GP1000B(W)

Polyamide 66

LG Chem Ltd.

Message:

Description

General Purpose, Low Viscosity

Applications

Buckles, Chair Nob

General Information			
UL YellowCard	E302314-530089	E67171-305829	
Features	General Purpose		
	Low Viscosity		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.14	g/cm³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.3 to 2.0	%	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 (Break, 3.20 mm)	80.4	MPa	ASTM D638
Tensile Elongation ² (Break, 3.20 mm)	50	%	ASTM D638
Flexural Modulus ³ (6.40 mm)	2750	MPa	ASTM D790
Flexural Strength ⁴ (Yield, 6.40 mm)	113	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	230	°C	
1.8 MPa, Unannealed, 6.40 mm	75.0	°C	
Peak Melting Temperature	260	°C	ASTM D3418
CLTE - Flow	8.0E-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)	23	kV/mm	ASTM D149
Dielectric Constant (1 MHz)	3.00		ASTM D150
Arc Resistance	190	sec	ASTM D495
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.700 mm)	V-2		UL 94

Injection	Nominal Value	Unit
Drying Temperature	80.0 to 100	°C
Drying Time	4.0 to 5.0	hr
Suggested Max Moisture	0.10	%
Rear Temperature	255 to 270	°C
Middle Temperature	260 to 275	°C
Front Temperature	260 to 275	°C
Nozzle Temperature	260 to 280	°C
Processing (Melt) Temp	260 to 280	°C
Mold Temperature	60.0 to 90.0	°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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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

