

LUMID HI1202BW

Injection Molding, PA66

Description

High Impact

Application

Automotive(Covers)

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.07
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	1.4 ~ 1.8
Water Absorption	23 °C, 24hrs	ASTM D570	%	1.1
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	530
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	50mm/min		%	> 50
Flexural Strength, 6.4mm	2.8mm/min	ASTM D790	kg/cm ²	650
Flexural Modulus, 6.4mm	2.8mm/min	ASTM D790	kg/cm ²	18,000
IZOD Impact Strength, 6.4mm (Notched)	23 °C	ASTM D256	kg-cm/cm	85
Thermal				
Melting Temperature		ASTM D3418	°C	260
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	70
	4.6kg		°C	210

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection moulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Updated : 18-Apr-18

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Electrical

Surface Resistivity		IEC 60093	Ohm	
Volume Resistivity	23 °C	ASTM D257	Ohm·m	1.0E+14
Arc Resistance	23 °C	ASTM D495	sec	
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	24
Dielectric Constant (10 ⁶ Hz)	23 °C	ASTM D150	sec	3

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		°C	80 ~ 100
Drying Time		hrs	4 ~ 5
Minimum Moisture Content		%	0.1
Melt Temperature		°C	270 ~ 280
Cylinder Temperature	Rear	°C	260 ~ 275
	Middle	°C	265 ~ 275
	Front	°C	270 ~ 280
Nozzle Temperature		°C	270 ~ 280
Mold Temperature		°C	60 ~ 90
Back Pressure		kg/cm ²	300 ~ 600
Screw Speed		rpm	30 ~ 60

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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