

LUMID HI1202A(W)

Injection Molding, PA6

Description

High Impact

Application

Electric/Electronic Parts

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity	23℃	ASTM D792	-	1.07
Molding Shrinkage (Flow), 3.2mm	23℃	ASTM D955	%	1.4 ~ 1.8
Water Absorption		ASTM D570	%	1.1
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	420
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℃	ASTM D256	kg·cm/cm	90
	-30℃		kg·cm/cm	
Rockwell Hardness	R-Scale	ASTM D785	-	110
Thermal				
Melting Temperature		ASTM D3418	℃	220
Heat Deflection Temperature, 6.4mm	4.6kg	ASTM D648	℃	160

Updated : 18-Apr-18

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Electrical

Property	Temperature	Standard	Unit	Value
Surface Resistivity		IEC 60093	Ohm	
Volume Resistivity	23 °C	ASTM D257	Ohm·m	1.0E+15
Arc Resistance	23 °C	ASTM D495	sec	195
Dielectric Strength, 1mm	23 °C	ASTM D149	kV/mm	20
Dielectric Constant (10 ⁶ Hz)	23 °C	ASTM D150	sec	2.8

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 molded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

Processing Guide (Injection Molding)

Processing Parameters	Unit	Value	
Drying Temperature	°C	80 ~ 100	
Drying Time	hrs	4 ~ 5	
Maximum Moisture Content	%		
Melt Temperature	°C	250 ~ 280	
Cylinder Temperature	Rear	°C	230 ~ 260
	Middle	°C	240 ~ 270
	Front	°C	250 ~ 280
Nozzle Temperature	°C	250 ~ 280	
Mold Temperature	°C	60 ~ 80	
Back Pressure	kg/cm ²		
Screw Speed	rpm		

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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