

**LUMID HI5006A(W)**

(PA6+ABS)

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.001	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Strength at Yield	44.1	MPa	ASTM D 638
Elongation at Break	100	%	ASTM D 638
Flexural Modulus	1570	MPa	ASTM D 790
Flexural Strength	58.9	MPa	ASTM D 790
Izod Impact notched, 1/4 in	660	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Coefficient of Thermal Expansion, MD	80	E-6/K	ASTM D 696
DTUL @ 66 psi	110	°C	ASTM D 648
DTUL @ 264 psi	80	°C	ASTM D 648
Melting Temperature	220	°C	ASTM D 3418

Electrical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Dielectric Strength, Short Time	26	kV/mm	ASTM D 149
Dielectric Constant, 1 MHz	2.9	-	ASTM D 150
Volume Resistivity	1E17	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.7	%	ASTM D 570
Density	1060	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	70 - 90	°C	-
Pre-drying - Time	4 - 5	h	-
Melt temperature	250 - 265	°C	-
Mold temperature	80 - 100	°C	-
Zone 1	235 - 250	°C	-
Zone 2	240 - 260	°C	-
Zone 3	240 - 260	°C	-
Nozzle temperature	250 - 265	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific, South and Central America

**Special Characteristics**

High impact or impact modified