

LUMID SG4389B

PA66-(GF+MF)38

LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Break	128	MPa	ASTM D 638
Elongation at Break	3.4	%	ASTM D 638
Flexural Modulus	6671	MPa	ASTM D 790
Flexural Strength	172	MPa	ASTM D 790
Rockwell Hardness	R 122	-	ASTM D 785
Izod Impact notched, 1/8 in	60.3	J/m	ASTM D 256
Izod Impact notched, 1/4 in	62.2	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
Coefficient of Thermal Expansion, MD	40	E-6/K	ASTM D 696
DTUL @ 264 psi	238	°C	ASTM D 648
Melting Temperature	260	°C	ASTM D 3418

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Dielectric Strength, Short Time	21	kV/mm	ASTM D 149
Volume Resistivity	1E16	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.7	%	ASTM D 570
Density	1430	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80 - 100	°C	-
Pre-drying - Time	4 - 5	h	-
Processing humidity	≤0.06	%	-
Melt temperature	275 - 285	°C	-
Mold temperature	80 - 110	°C	-
Zone 1	260 - 270	°C	-
Zone 2	270 - 280	°C	-
Zone 3	280 - 290	°C	-
Nozzle temperature	280 - 290	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	30 - 60	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

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

Applications

Automotive