LUMID HI1102B(W)

PA66 LG Chem

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	**0.014**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength at Yield	**63.8**	MPa	ASTM D 638
Elongation at Break	**40**	%	ASTM D 638
Flexural Modulus	**2158**	MPa	ASTM D 790
Flexural Strength	**79.5**	MPa	ASTM D 790
Rockwell Hardness	**R 113**	-	ASTM D 785
Izod Impact notched, 1/8 in	**189**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
Coefficient of Thermal Expansion, MD	**70**	E-6/K	ASTM D 696
DTUL @ 66 psi	**225**	°C	ASTM D 648
DTUL @ 264 psi	**70**	°C	ASTM D 648
Melting Temperature	**260**	°C	ASTM D 3418

Electrical properties	Value	Unit	Test Standard
ASTM Data			
Dielectric Strength, Short Time	**24**	kV/mm	ASTM D 149
Dielectric Constant, 1 MHz	**3**	-	ASTM D 150
Volume Resistivity	**1E16**	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	**1.3**	%	ASTM D 570
Density	**1100**	kg/m³	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	**≤0.1**	%	-
Melt temperature	**270 - 280**	°C	-
Mold temperature	**60 - 90**	°C	-
Zone 1	**260 - 275**	°C	-
Zone 2	**265 - 275**	°C	-
Zone 3	**270 - 280**	°C	-
Nozzle temperature	**270 - 280**	°C	-
Screw speed	**30 - 60**	rpm	-
Back pressure	**30 - 60**	MPa	-

Characteristics

Processing
Injection Molding

Applications
Automotive

Special Characteristics
High impact or impact modified

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