

LUMID HI5006A(W)

Injection Molding, PA6/ABS

Description

High Impact, Good Dimensional Stability

Application

Pipe Fitting

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity	23℃	ASTM D792	-	1.06
Molding Shrinkage, 3.2mm	23℃	ASTM D955	%	0.8 ~ 1.2
Melt Flow Rate		ASTM D1238	g/10min	
Water Absorption		ASTM D570	%	0.7
Mechanical				
Tensile Strength, 3.2mm		ASTM D638		
@ Yield	50mm/min		kg/cm ²	450
Tensile Elongation, 3.2mm		ASTM D638		
@ Break	50mm/min		%	100
Flexural Strength, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	600
Flexural Modulus, 3.2mm	1.3mm/min	ASTM D790	kg/cm ²	16,000
IZOD Impact Strength, 6.4mm (Notched)	23℃ -30℃	ASTM D256	kg·cm/cm kg·cm/cm	
IZOD Impact Strength, 3.2mm (Notched)	23℃ -30℃	ASTM D256	kg·cm/cm kg·cm/cm	70
Rockwell Hardness	R-Scale	ASTM D785	-	
Thermal				
Melting Temperature		ASTM D3418	℃	220
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg 4.6kg	ASTM D648	℃ ℃	80 110
Coefficient of Linear Thermal Expansion		ASTM D696		
Flow			10 ⁻⁵ m/m℃	8
Cross-flow			10 ⁻⁵ m/m℃	
Flammability		UL94		
0.8mm			class	
1.6mm			class	
2.5mm			class	
3.2mm			class	

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℃, 50% relative humidity.

Updated : 1-Jun-14

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Electrical

Surface Resistivity		IEC 60093	Ohm	
Volume Resistivity	23℃	ASTM D257	Ohm·cm	1.0E+15
Arc Resistance	23℃	ASTM D495	sec	
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm	26
Dielectric Constant (10 ⁶ Hz)	23℃	ASTM D150		2.9

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Processing Guide (Injection Molding)

Processing Parameters		Unit	Value
Drying Temperature		℃	70 ~ 90
Drying Time		hrs	4 ~ 5
Maximum Moisture Content		%	0.12
Melt Temperature		℃	250 ~ 265
Cylinder Temperature	Rear	℃	235 ~ 250
	Middle	℃	240 ~ 260
	Front	℃	240 ~ 260
Nozzle Temperature		℃	250 ~ 265
Mold Temperature		℃	80 ~ 100
Back Pressure	Hydraulic Type	kg/cm ²	5~20
	Electric Type		50~200
Screw Speed		rpm	60~200

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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