

LG Chemical LUMID SG4389B PA66+GF/MF38%

Category : Polymer , Thermoplastic , Nylon , Nylon 66 , Nylon 66, Glass/Mineral Filled

Material Notes:

Feature: Injection Molding, PA66+GF/MF38% Application: Automotive (Fan & Shroud) CAS No. 32131-17-2, 25038-54-4, 65997-17-3 and 14807-96-6 Information provided by LG Chemical

Order this product through the following link:

http://www.lookpolymers.com/polymer_LG-Chemical-LUMID-SG4389B-PA66GFMF38.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.43 g/cc	1.43 g/cc	ASTM D792
Water Absorption	0.70 % @Temperature 23.0 Â°C, Time 86400 sec	0.70 % @Temperature 73.4 Â°F, Time 24.0 hour	ASTM D570
Maximum Moisture Content	0.060	0.060	Injection Molding
Linear Mold Shrinkage, Flow	0.0030 - 0.0090 cm/cm @Thickness 3.20 mm	0.0030 - 0.0090 in/in @Thickness 0.126 in	ASTM D955

Mechanical Properties	Metric	English	Comments
Hardness, Rockwell R	122	122	ASTM D785
Tensile Strength, Yield	127 MPa @Thickness 3.20 mm	18500 psi @Thickness 0.126 in	5mm/min; ASTM D638
Elongation at Break	3.4 % @Thickness 3.20 mm	3.4 % @Thickness 0.126 in	5mm/min; ASTM D638
Flexural Yield Strength	172 MPa @Thickness 3.20 mm	24900 psi @Thickness 0.126 in	1.3mm/min; ASTM D790
Flexural Modulus	6.67 GPa @Thickness 3.20 mm	967 ksi @Thickness 0.126 in	1.3mm/min; ASTM D790
Izod Impact, Notched	0.628 J/cm @Thickness 3.20 mm, Temperature 23.0 Â°C	1.18 ft-lb/in @Thickness 0.126 in, Temperature 73.4 Â°F	ASTM D256
	0.647 J/cm @Thickness 6.40 mm, Temperature 23.0 Â°C	1.21 ft-lb/in @Thickness 0.252 in, Temperature 73.4 Â°F	ASTM D256

Thermal Properties	Metric	English	Comments
CTE, linear, Parallel to Flow	40.0 $\mu\text{m}/\text{m}\cdot\text{Å}^\circ\text{C}$	22.2 $\mu\text{in}/\text{in}\cdot\text{Å}^\circ\text{F}$	ASTM D696
Melting Point	260 $\text{Å}^\circ\text{C}$	500 $\text{Å}^\circ\text{F}$	ASTM D3418
Deflection Temperature at 1.8 MPa (264 psi)	238 $\text{Å}^\circ\text{C}$ @Thickness 6.40 mm	460 $\text{Å}^\circ\text{F}$ @Thickness 0.252 in	Unannealed; ASTM D648

Electrical Properties	Metric	English	Comments
Volume Resistivity	1.00e+14 ohm-cm	1.00e+14 ohm-cm	ASTM D257
Dielectric Strength	21.0 kV/mm @Thickness 1.00 mm	533 kV/in @Thickness 0.0394 in	ASTM D149

Processing Properties	Metric	English	Comments
Rear Barrel Temperature	260 - 270 $\text{Å}^\circ\text{C}$	500 - 518 $\text{Å}^\circ\text{F}$	Injection Molding
Middle Barrel Temperature	270 - 280 $\text{Å}^\circ\text{C}$	518 - 536 $\text{Å}^\circ\text{F}$	Injection Molding
Front Barrel Temperature	280 - 290 $\text{Å}^\circ\text{C}$	536 - 554 $\text{Å}^\circ\text{F}$	Injection Molding
Nozzle Temperature	280 - 290 $\text{Å}^\circ\text{C}$	536 - 554 $\text{Å}^\circ\text{F}$	Injection Molding
Melt Temperature	275 - 285 $\text{Å}^\circ\text{C}$	527 - 545 $\text{Å}^\circ\text{F}$	Injection Molding
Mold Temperature	80.0 - 110 $\text{Å}^\circ\text{C}$	176 - 230 $\text{Å}^\circ\text{F}$	Injection Molding
Drying Temperature	80.0 - 100 $\text{Å}^\circ\text{C}$	176 - 212 $\text{Å}^\circ\text{F}$	Injection Molding
Dry Time	4.00 - 5.00 hour	4.00 - 5.00 hour	Injection Molding
Back Pressure	29.4 - 58.8 MPa	4260 - 8530 psi	Injection Molding
Screw Speed	30 - 60 rpm	30 - 60 rpm	Injection Molding

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