

# LUMID GP2300BW

Injection, PA66+GF30%

Description  
Injection grade

Application  
Electric parts

Properties	Test Condition	Test Method	Unit	Typical Value
Physical				
Specific Gravity		ASTM D792	-	1.37
Molding Shrinkage (Flow), 3.2mm		ASTM D955	%	0.4~0.9
Melt Flow Rate		ASTM D1238	g/10min	1.1
Water Absorption	23°C, 24hrs	ASTM D570	%	
Mechanical				
Tensile Strength, 3.2mm @ Break	5mm/min	ASTM D638	kg/cm2	1,750
Tensile Elongation, 3.2mm @ Break	5mm/min	ASTM D638	%	2.8
Flexural Strength, 3.2mm	3.0mm/min	ASTM D790	kg/cm2	2,500
Flexural Modulus, 3.2mm	3.0mm/min	ASTM D790	kg/cm2	83,000
IZOD Impact Strength, 3.2mm (Notched)	23°C	ASTM D256	kg·cm/cm	9
	-30°C		kg·cm/cm	
Thermal				
Melting Temperature		ASTM D3418	°C	260
Heat Deflection Temperature, 6.4mm (Unannealed)	18.6kg	ASTM D648	°C	255
Coefficient of Linear Thermal Expansion	4.6kg		°C	
Flow Cross-flow		ASTM D696	10 <sup>-5</sup> m/m°C 10 <sup>-5</sup> m/m°C	3
Ball Pressure Temperature		IEC 60695-10-2	°C	
Burning Rate, 3.2mm		FMVSS 302	mm	
Flammability		UL94		
0.75mm			class	HB
1.5mm			class	HB
3.0mm			class	HB
Relative Temperature Index		UL 746B		
Electrical		120	°C	
Mechanical with Impact		110	°C	
Mechanical without Impact		120	°C	

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 molulded specimens and after 48 hours storage at 23 °C, 50% relative humidity.

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## Electrical

Surface Resistivity		IEC 60093	Ohm	
Volume Resistivity	23℃	ASTM D257	Ohm·cm	1.0E+14
Arc Resistance	23℃	ASTM D495	sec	
Dielectric Strength, 1mm	23℃	ASTM D149	kV/mm	25
Dielectric Constant (106 Hz)	23℃	ASTM D150		4

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## Processing Guide (Extrusion Molding)

Processing Parameters			Unit	Value
Drying Temperature Drying			℃	80 ~ 100
Time Minimum Moisture			hrs	4 ~ 5
Content			%	260 ~ 290
Melt Temperature			℃	250 ~ 270
Cylinder Temperature	Rear		℃	260 ~ 285
	Middle		℃	260 ~ 290
	Front		℃	260 ~ 290
Nozzle Temperature			℃	80 ~ 100
Mold Temperature			℃	
Back Pressure			kg/cm2	
Screw Speed			rpm	

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.