LNP™ THERMOTUF™ COMPOUND PF003IU

DESCRIPTION

LNP™ THEMROTUF™ PF003IU is a Polyamide 6 compound,17% glass filled, fiber reinforced, with impact modifier and UV stabilized.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Flexural Modulus, 1.3 mm/min, 50 mm span	4100	MPa	ASTM D 790
Flexural Stress, yld, 1.3 mm/min, 50 mm span	145	MPa	ASTM D 790
Tensile Stress, brk, Type I, 50 mm/min	103	MPa	ASTM D 638
IMPACT			
Izod Impact, notched, 23°C	65	J/m	ASTM D 256
Izod Impact, unnotched, 23°C	610	J/m	ASTM D 4812
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	197	°C	ASTM D 648
HDT, 0.45 MPa, 3.2 mm, unannealed	215	°C	ASTM D 648
Vicat Softening Temp, Rate B/50	201	°C	ASTM D 1525
INJECTION MOLDING			
Drying Temperature	100 – 110	°C	
Drying Time	3	hrs	
Maximum Moisture Content	.02	%	
Melt Temperature	250 – 265	°C	
Nozzle Temperature	245 – 260	°C	
Front - Zone 3 Temperature	250 – 265	°C	
Middle - Zone 2 Temperature	245 – 260	°C	
Rear - Zone 1 Temperature	240 – 255	°C	
Mold Temperature	65 – 90	°C	
Screw Speed	50 – 80	rpm	
Back Pressure	0.3 – 0.7	MPa	

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