LNP™ THERMOTUF™ COMPOUND R1000I

R-1000 HI
REGION ASIA

DESCRIPTION

LNP THERMOTUF R1000I is a compound based on Nylon 66 resin containing Impact Modifier. Added feature of this material is: High Impact.

TYPICAL PROPERTY VALUES

Revision 20181227

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	45	MPa	ISO 527
Tensile Strain, break	70	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress	50	MPa	ISO 178
Flexural Modulus	1400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	98	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	55	kJ/m²	ISO 180/1A
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	65	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 24 hrs	1.1 – 1.5	%	ISO 294
Density	1.09	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	265 – 275	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	255 – 265	°C	
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	60 – 100	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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