LNP™ COLORCOMP™ COMPOUND I1000

I-1000

DESCRIPTION

LNP COLORCOMP I1000 is an unfilled Nylon 6/12

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Strain, brk, Type I, 5 mm/min	100	%	ASTM D 638
Tensile Stress, yield, 5 mm/min	62	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	4.5	%	ISO 527
Tensile Modulus, 1 mm/min	2390	MPa	ISO 527
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	55	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	135	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	62	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.06	-	ASTM D 792
Mold Shrinkage, flow, 24 hrs	1 – 3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
ELECTRICAL			
Volume Resistivity	1.E+15	Ohm-cm	ASTM D 257
Surface Resistivity	1.E+12	Ohm	ASTM D 257
Relative Permittivity, 100 Hz	3.6	-	ASTM D 150
Relative Permittivity, 1 MHz	3.2	-	ASTM D 150
Dissipation Factor, 100 Hz	0.02	-	ASTM D 150
Dissipation Factor, 1 kHz	0.02	-	ASTM D 150
Dissipation Factor, 100 kHz	0.014	-	ASTM D 150
FLAME CHARACTERISTICS			
Oxygen Index (LOI)	27	%	ISO 4589
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.12 – 0.2	%	
Melt Temperature	270 – 275	°C	
Front - Zone 3 Temperature	270 – 280	°C	
Middle - Zone 2 Temperature	260 – 270	°C	
Rear - Zone 1 Temperature	255 – 265	°C	
Mold Temperature	65 – 95	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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