LNP™ COLORCOMP™ COMPOUND R1000

R-1000

DESCRIPTION

LNP* COLORCOMP* R1000 is an unfilled Nylon 66.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	79	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	11	%	ISO 527
Tensile Strain, break, 5 mm/min	45	%	ISO 527
Tensile Modulus, 1 mm/min	2990	MPa	ISO 527
Flexural Stress	33	MPa	ISO 178
Flexural Modulus, 2 mm/min	2900	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
Charpy Impact, notched, 23°C	6	kJ/m²	ISO 179/2C
Charpy Impact, notched, -30°C	6	kJ/m²	ISO 179/2C
THERMAL			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	200	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	70	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	1.2	%	SABIC method
Mold Shrinkage, xflow	1.4	%	SABIC method
Density	1.14	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	275 – 290	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	280 – 295	°C	
Rear - Zone 1 Temperature	265 – 275	°C	
Mold Temperature	80 – 95	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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