LNP™ THERMOCOMP™ COMPOUND PB006EQ

DESCRIPTION

LNP *THERMOCOMP* PB006EQ is a compound based on PA 6 containing Glass Bead. Added features include Reduced Moisture.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	42	MPa	ISO 527
Tensile Strain, break, 5 mm/min	10	%	ISO 527
Flexural Stress, yield, 2 mm/min	56	MPa	ISO 178
Flexural Modulus, 2 mm/min	2400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	1.09E-04	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.16E-04	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	61	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	1.8	%	SABIC method
Density	1.26	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	255 – 275	°C	
Front - Zone 3 Temperature	265 – 275	°C	
Middle - Zone 2 Temperature	255 – 265	°C	
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	80 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	

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