LNP™ THERMOCOMP™ COMPOUND PB006SXS

PB-1006 HS

DESCRIPTION

LNP THERMOCOMP PB006SXS is a compound based on PA 6 resin containing Glass Bead. Added features include: Heat Stabilized.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	75	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5 – 7	%	ISO 527
Flexural Stress, yield, 2 mm/min	110	MPa	ISO 178
Flexural Modulus, 2 mm/min	3600	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	152	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	61	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	1.4 – 1.6	%	SABIC method
Density	1.33	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	2.5	%	ISO 62-1
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	275 – 290	°C	
Middle - Zone 2 Temperature	265 – 275	°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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