LNP™ THERMOCOMP™ COMPOUND PF008QS

PF-1008 HS RM

DESCRIPTION

LNP THERMOCOMP* PF008QS is a compound based on Nylon 6 resin containing 40% Glass Fiber. Added features of this material include: Heat Stabilized, Reduced Moisture.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	152	MPa	ASTM D 638
Tensile Strain, break	3	%	ASTM D 638
Tensile Modulus, 50 mm/min	12200	MPa	ASTM D 638
Flexural Stress	244	MPa	ASTM D 790
Flexural Modulus	9580	MPa	ASTM D 790
Tensile Stress, break	165	MPa	ISO 527
Tensile Strain, break	3.4	%	ISO 527
Tensile Modulus, 1 mm/min	11600	MPa	ISO 527
Flexural Stress	262	MPa	ISO 178
Flexural Modulus	12000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1105	J/m	ASTM D 4812
Izod Impact, notched, 23°C	170	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	12	J	ASTM D 3763
Multiaxial Impact	4	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	72	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	17	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	218	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	199	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.09E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.56E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.09E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.56E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	201	°C	ISO 75/Af
PHYSICAL			
Density	1.35	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.31	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.1 – 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.1 – 0.3	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.7 – 0.9	%	ISO 294
Density	1.35	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.5	%	ISO 62

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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