# LNP™ THERMOCOMP™ COMPOUND PF00DS

PF10013HS

## DESCRIPTION

LNP THERMOCOMP* PF00DS is a compound based on PA6 resin containing Glass Fiber. Added features of this material include: Heat Stabilized.

## TYPICAL PROPERTY VALUES

Revision 20191213

| PROPERTIES | TYPICAL VALUES | UNITS | TEST METHODS |
|---|---|---|---|
| MECHANICAL | | | |
| Tensile Stress, break, 5 mm/min | 235 | MPa | ISO 527 |
| Tensile Strain, break, 5 mm/min | 1.8 | % | ISO 527 |
| Flexural Stress, break, 2 mm/min | 335 | MPa | ISO 178 |
| Flexural Modulus, 2 mm/min | 19000 | MPa | ISO 178 |
| IMPACT | | | |
| Izod Impact, unnotched 80*10*4 +23°C | 65 | kJ/m² | ISO 180/1U |
| Izod Impact, notched 80*10*4 +23°C | 14 | kJ/m² | ISO 180/1A |
| THERMAL | | | |
| CTE, 23°C to 60°C, flow | 1.E-05 | 1/°C | ISO 11359-2 |
| CTE, 23°C to 60°C, xflow | 6.E-05 | 1/°C | ISO 11359-2 |
| HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm | 220 | °C | ISO 75/Ae |
| PHYSICAL | | | |
| Mold Shrinkage, flow | 0.1 – 0.2 | % | SABIC method |
| Density | 1.7 | g/cm³ | ISO 1183 |
| FLAME CHARACTERISTICS | | | |
| UL Compliant, 94HB Flame Class Rating | 0.8 | mm | UL 94 by SABIC-IP |
| 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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