LNP™ THERMOCOMP™ COMPOUND PF00DS-BK1G298

PF10013HS

DESCRIPTION

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

TYPICAL PROPERTY VALUES

Revision 20191218

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
ELECTRICAL			
Surface Resistivity	1.E+14	Ohm	ASTM D 257
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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