LNP™ THERMOCOMP™ COMPOUND PFB55

DESCRIPTION

LNP THERMOCOMP PFB55 is a compound based on PA 6 resin containing Glass Bead, Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	155	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.7	%	ISO 527
Tensile Modulus, 1 mm/min	10900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	229	MPa	ISO 178
Flexural Modulus, 2 mm/min	10000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	50	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	2.9E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	7.5E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	204	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.2 – 0.4	%	SABIC method
Density	1.56	g/cm³	ISO 1183
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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