LNP™ THERMOCOMP™ COMPOUND PFB91S

PDX-P-00461
REGION ASIA

DESCRIPTION

LNP THERMOCOMP PFB91S is a compound based on Nylon 6 resin containing Proprietary Filler(s).

TYPICAL PROPERTY VALUES

Revision 20181031

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	62	MPa	ASTM D 638
Tensile Strain, break	2.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	7490	MPa	ASTM D 638
Flexural Modulus	6040	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	283	J/m	ASTM D 4812
Izod Impact, notched, 23°C	37	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	163	°C	ASTM D 648
PHYSICAL			
Density	1.57	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.6	%	ASTM D 955
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	265 – 270	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	250 – 260	°C	
Rear - Zone 1 Temperature	240 – 250	°C	
Mold Temperature	80 – 95	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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