LNP™ THERMOCOMP™ COMPOUND SF00A

SF-100-10
REGION ASIA

DESCRIPTION

LNP THERMOCOMP SF00A is a compound based on Nylon 12 resin containing 50% Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20190816

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	121	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	121	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	12800	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	217	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	217	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	10984	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	113	MPa	ISO 527
Tensile Stress, break, 5 mm/min	113	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	1.5	%	ISO 527
Tensile Strain, break, 5 mm/min	1.5	%	ISO 527
Tensile Modulus, 1 mm/min	12280	MPa	ISO 527
Flexural Modulus, 2 mm/min	10	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	833	J/m	ASTM D 4812
Izod Impact, notched, 23°C	160	J/m	ASTM D 256
Multiaxial Impact	16	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	1	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	176	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	166	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	176	°C	ISO 75/Af
PHYSICAL			
Density	1.48	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.8 – 1	%	ASTM D 955
Density	1.48	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.12 – 0.2	%	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	225 – 240	°C	
Front - Zone 3 Temperature	225 – 240	°C	
Middle - Zone 2 Temperature	220 – 230	°C	
Rear - Zone 1 Temperature	215 – 225	°C	
Mold Temperature	70 – 80	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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