LNP™ THERMOCOMP™ COMPOUND UF006AS

UF-1006 A HS

DESCRIPTION

LNP THERMOCOMP* UF006AS is a compound based on Polyphthalamide resin containing 30% Glass Fiber. Added features of this material include: Heat Stabilized.

TYPICAL PROPERTY VALUES

Revision 20191219

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	182	MPa	ASTM D 638
Tensile Strain, break	1.9	%	ASTM D 638
Tensile Modulus, 50 mm/min	11600	MPa	ASTM D 638
Flexural Stress	254	MPa	ASTM D 790
Flexural Modulus	11530	MPa	ASTM D 790
Tensile Stress, break	167	MPa	ISO 527
Tensile Strain, break	1.6	%	ISO 527
Tensile Modulus, 1 mm/min	14790	MPa	ISO 527
Flexural Stress	255	MPa	ISO 178
Flexural Modulus	11220	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	411	J/m	ASTM D 4812
Izod Impact, notched, 23°C	69	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	9	J	ASTM D 3763
Multiaxial Impact	1	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	7	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	282	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	260	°C	ISO 75/Af
PHYSICAL			
Density	1.454	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.22	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.24	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.97	%	ISO 294
Density	1.45	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.41	%	ISO 62
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15	%	
Melt Temperature	315 – 330	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Front - Zone 3 Temperature	325 – 340	°C	
Middle - Zone 2 Temperature	315 – 325	°C	
Rear - Zone 1 Temperature	310 – 320	°C	
Mold Temperature	140 – 165	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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