LNP™ THERMOCOMP™ COMPOUND UFW49RSC

UFM-3249 HS-S VDO

DESCRIPTION

LNP THERMOCOMP UFW49RSC is a compound based on Polyphthalamide resin containing Glass Fiber, Mineral. Added features include: Heat Stabilized.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	186	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	1.1	%	ISO 527
Tensile Modulus, 1 mm/min	20800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	278	MPa	ISO 178
Flexural Modulus, 2 mm/min	18100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	40	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	1.6E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	3.6E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	255	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.1 – 0.3	%	SABIC method
Density	1.87	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15	%	
Melt Temperature	315 – 330	°C	
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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