LNP™ THERMOCOMP™ COMPOUND VF008A

PDX-83363

DESCRIPTION

LNP THERMOCOMP VF008A is a compound based on High Impact Nylon 66 containing 40% Glass Fiber.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	158	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3 – 4	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	227	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	8270	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	1010	J/m	ASTM D 4812
Izod Impact, notched 80*10*4 +23°C	187	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	249	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.41	-	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.6	%	ASTM D 570
Mold Shrinkage, flow	0.4	%	SABIC method
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15	%	
Melt Temperature	280 – 295	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	275 – 290	°C	
Rear - Zone 1 Temperature	260 – 270	°C	
Mold Temperature	95 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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