LNP™ STAT-LOY™ COMPOUND PF306

PF-30

DESCRIPTION

LNP* STAT-LOY* PF306 is a compound based on Nylon 6 resin containing 30% Glass Fiber. Added feature of this grade includes: Antistat.

TYPICAL PROPERTY VALUES

Revision 20191212

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	93	MPa	ASTM D 638
Tensile Stress, break	93	MPa	ASTM D 638
Tensile Strain, yield	2.7	%	ASTM D 638
Tensile Strain, break	2.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	7580	MPa	ASTM D 638
Flexural Stress	96	MPa	ASTM D 790
Flexural Modulus	5510	MPa	ASTM D 790
Tensile Stress, yield	83	MPa	ISO 527
Tensile Stress, break	83	MPa	ISO 527
Tensile Strain, yield	2.7	%	ISO 527
Tensile Strain, break	2.8	%	ISO 527
Tensile Modulus, 1 mm/min	7470	MPa	ISO 527
Flexural Stress	106	MPa	ISO 178
Flexural Modulus	6000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	955	J/m	ASTM D 4812
Izod Impact, notched, 23°C	101	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	17	J	ASTM D 3763
Multiaxial Impact	6	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	45	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	202	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	185	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.19E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	3.96E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	1.19E-04	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	4.E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	201	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	182	°C	ISO 75/Af
PHYSICAL			
Density	1.39	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	5.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, xflow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.28	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.82	%	ISO 294
Density	1.39	g/cm³	ISO 1183
ELECTRICAL			
Surface Resistivity	1.E+09 – 1.E+11	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	265 – 275	°C	
Front - Zone 3 Temperature	275 – 290	°C	
Middle - Zone 2 Temperature	265 – 275	°C	
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	80 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	

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