LNP™ THERMOCOMP™ Compound PF00DS
Europe-Africa-Middle East: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PF10013HS
Product reorder name: PF00DS

LNP THERMOCOMP* PF00DS is a compound based on PA6 resin containing Glass Fiber. Added features of this material include: Heat Stabilized.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break, 5 mm/min	235	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.8	%	ISO 527
Flexural Stress, break, 2 mm/min	335	MPa	ISO 178
Flexural Modulus, 2 mm/min	19000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	65	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	1.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.E-05	1/°C	ISO 11359-2
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	220	°C	ISO 75/Ae
PHYSICAL			
Mold Shrinkage, flow (5)	0.1 - 0.2	%	SABIC Method
Density	1.7	g/cm³	ISO 1183
FLAME CHARACTERISTICS			
UL Compliant, 94HB Flame Class Rating (3)(4)	0.8	mm	UL 94 by SABIC-IP

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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