LNP™ THERMOTUF™ Compound PF008IR

Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound PF-1008 HI MR
Product reorder name: PF008IR

LNP THERMOTUF PF008IR is a compound based on Nylon 6 resin containing 40% Glass Fiber. Added features of this material include: High Impact, Mold Release.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1460	kgf/cm²	ASTM D 638
Tensile Strain, break	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	133500	kgf/cm²	ASTM D 638
Flexural Stress	2600	kgf/cm²	ASTM D 790
Flexural Modulus	100500	kgf/cm²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	114	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	14	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	205	°C	ASTM D 648
PHYSICAL			
Density	1.46	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.3	%	ASTM D 955

LNP™ THERMOTUF™ Compound PF008IR

Americas: COMMERCIAL

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