



LNP™ THERMOCOMP™ Compound PFB55

Europe-Africa-Middle East: COMMERCIAL

LNP THERMOCOMP PFB55 is a compound based on PA 6 resin containing Glass Bead, Glass Fiber.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield, 5 mm/min	155	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.7	%	ISO 527
Tensile Modulus, 1 mm/min	10900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	229	MPa	ISO 178
Flexural Modulus, 2 mm/min	10000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	50	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m ²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	2.9E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	7.5E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	204	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow (5)	0.2 - 0.4	%	SABIC Method
Density	1.56	g/cm ³	ISO 1183



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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