

LNP* Thermocomp* Compound R-1000 HI 620

Asia Pacific: COMMERCIAL

High Impact Nylon 66 compound containing Impact Modifier.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, break	40	MPa	ISO 527
Tensile Strain, break	40	%	ISO 527
Tensile Modulus, 1 mm/min	1700	MPa	ISO 527
Flexural Stress	45	MPa	ISO 178
Flexural Modulus	1400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	98	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	120	kJ/m ²	ISO 180/1A
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	45	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow, 24 hrs	2.3 - 2.5	%	ISO 294
Density	1.07	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	260 - 270	°C
Middle - Zone 2 Temperature	255 - 265	°C
Rear - Zone 1 Temperature	250 - 260	°C
Mold Temperature	60 - 100	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm