



## LNP™ THERMOTUF™ Compound OF006I

### Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound OF-1006 HI

Product reorder name: OF006I

LNP THERMOTUF™ OF006I is a compound based on PPS - Linear resin containing Glass Fiber. Added features of this material include: High Impact.

| TYPICAL PROPERTIES <sup>1</sup>         | TYPICAL VALUE | Unit                | Standard    |
|-----------------------------------------|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                       |               |                     |             |
| Tensile Stress, break                   | 1460          | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, break                   | 2.4           | %                   | ASTM D 638  |
| Tensile Modulus, 50 mm/min              | 110300        | kgf/cm <sup>2</sup> | ASTM D 638  |
| Flexural Stress                         | 2110          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus                        | 99800         | kgf/cm <sup>2</sup> | ASTM D 790  |
| Tensile Stress, break                   | 139           | MPa                 | ISO 527     |
| Tensile Strain, break                   | 2             | %                   | ISO 527     |
| Tensile Modulus, 1 mm/min               | 9820          | MPa                 | ISO 527     |
| Flexural Stress                         | 212           | MPa                 | ISO 178     |
| Flexural Modulus                        | 10060         | MPa                 | ISO 178     |
| <b>IMPACT</b>                           |               |                     |             |
| Izod Impact, unnotched, 23°C            | 79            | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C              | 17            | cm-kgf/cm           | ASTM D 256  |
| Instrumented Impact Energy @ peak, 23°C | 136           | cm-kgf              | ASTM D 3763 |
| Multiaxial Impact                       | 49            | cm-kgf              | ISO 6603    |
| Izod Impact, unnotched 80*10*4 +23°C    | 50            | kJ/m <sup>2</sup>   | ISO 180/1U  |
| Izod Impact, notched 80*10*4 +23°C      | 16            | kJ/m <sup>2</sup>   | ISO 180/1A  |
| <b>PHYSICAL</b>                         |               |                     |             |
| Density                                 | 1.486         | g/cm <sup>3</sup>   | ASTM D 792  |
| Moisture Absorption, 50% RH, 24 hrs     | 0.04          | %                   | ASTM D 570  |
| Mold Shrinkage, flow, 24 hrs (5)        | 0.2           | %                   | ASTM D 955  |
| Mold Shrinkage, xflow, 24 hrs (5)       | 0.7           | %                   | ASTM D 955  |
| Mold Shrinkage, flow, 24 hrs (5)        | 0.23          | %                   | ISO 294     |



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|-----------------------------------|---------------|-------------------|----------|
| <b>PHYSICAL</b>                   |               |                   |          |
| Mold Shrinkage, xflow, 24 hrs (5) | 0.67          | %                 | ISO 294  |
| Density                           | 1.48          | g/cm <sup>3</sup> | ISO 1183 |



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| PROCESSING PARAMETERS       | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| Drying Temperature          | 120 - 150     | °C   |
| Drying Time                 | 4             | hrs  |
| Melt Temperature            | 315 - 320     | °C   |
| Front - Zone 3 Temperature  | 330 - 345     | °C   |
| Middle - Zone 2 Temperature | 320 - 330     | °C   |
| Rear - Zone 1 Temperature   | 305 - 315     | °C   |
| Mold Temperature            | 140 - 165     | °C   |
| Back Pressure               | 0.2 - 0.3     | MPa  |
| Screw Speed                 | 30 - 60       | rpm  |