

LNPTM COLORCOMPTM COMPOUND R1000S

R-1000 HS

DESCRIPTION

LNP COLORCOMP R1000S compound is based on Nylon 6/6 resin. Added features of this grade include: Heat Stabilised.

GENERAL INFORMATION

Features	Heat Stabilized, Aesthetics/Visual effects, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polyamide 66 (Nylon 66)
Processing Techniques	Injection Molding

INDUSTRY

Automotive
Consumer
Electrical and Electronics

SUB INDUSTRY

Automotive Interiors
Home Decoration, Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Mobile Phone - Computer - Tablets

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, yield	75	MPa	ISO 527
Tensile Strain, yield	10	%	ISO 527
Tensile Modulus, 1 mm/min	3400	MPa	ISO 527
Flexural Stress	11	MPa	ISO 178
Flexural Modulus	3200	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	75	°C	ISO 75/Af
PHYSICAL ⁽¹⁾			
Density	1.22	g/cm ³	ASTM D792
Density	1.23	g/cm ³	ISO 1183
INJECTION MOLDING ⁽²⁾			
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	



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

ADDITIONAL PRODUCT NOTES

No PFAS intentionally added: The grade listed in this document does not contain PFAS intentionally added during Seller's manufacturing process and is not expected to contain unintentional PFAS impurities. Each user is responsible for evaluating the presence of unintentional PFAS impurities.

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