

LNPTTM THERMOCOMPTM COMPOUND PF00DS-BK1G298

PF10013HS

DESCRIPTION

LNP THERMOCOMP PF00DS compound is based on PA6 resin containing glass fiber. Added features of this grade include: Heat Stabilized, Custom color Black.

GENERAL INFORMATION

Features	Heat Stabilized, High stiffness/Strength
Fillers	Glass Fiber
Polymer Types	Polyamide 6 (Nylon 6)
Processing Techniques	Injection Molding

INDUSTRY

Building and Construction
Consumer
Electrical and Electronics
Industrial

SUB INDUSTRY

Building Component
Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Mobile Phone - Computer - Tablets
Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, break, 5 mm/min	235	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.8	%	ISO 527
Flexural Stress, break, 2 mm/min	335	MPa	ISO 178
Flexural Modulus, 2 mm/min	19000	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, unnotched 80*10*4 +23°C	65	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
CTE, 23°C to 60°C, flow	1.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.E-05	1/°C	ISO 11359-2
HDT/Ae, 1.8 MPa Edgew 120*10*4 sp=100mm	220	°C	ISO 75/Ae
PHYSICAL ⁽¹⁾			
Mold Shrinkage, flow ⁽²⁾	0.1 – 0.2	%	SABIC method
Density	1.7	g/cm ³	ISO 1183
ELECTRICAL ⁽¹⁾			
Surface Resistivity	1.E+14	Ω	ASTM D257
FLAME CHARACTERISTICS			

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
UL Compliant, 94HB Flame Class Rating ⁽³⁾	0.8	mm	UL 94 by SABIC-IP
INJECTION MOLDING ⁽⁴⁾			
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	

(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) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(3) UL rating shown here is based on internal measurements.

(4) 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.

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