

Complet® LGF60-TPU

Engineering Thermoplastic Polyurethane

PlastiComp, Inc.

Message:

Complet® LGF60-TPU is an engineering thermoplastic polyurethane (ETPU) product, which contains 60% long glass fiber as filler. It is available in North America, Europe or Asia Pacific. The main features are: Rohs certification.

General Information			
Filler / Reinforcement	Long glass fiber, 60% filler by weight		
RoHS Compliance	RoHS compliance		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.71	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	20700	MPa	ASTM D638
Tensile Strength	283	MPa	ASTM D638
Tensile Elongation (Break)	2.0 - 3.0	%	ASTM D638
Flexural Modulus	15200	MPa	ASTM D790
Flexural Strength	405	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	550	J/m	ASTM D256
Unnotched Izod Impact	1500	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	113	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	87.8	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Suggested Max Regrind	5	%	
Rear Temperature	204 - 227	°C	
Middle Temperature	210 - 232	°C	
Front Temperature	216 - 238	°C	
Nozzle Temperature	221 - 243	°C	
Processing (Melt) Temp	216 - 238	°C	
Mold Temperature	87.8	°C	
Back Pressure	0.172 - 0.345	MPa	
Screw Speed	30 - 50	rpm	
Cushion	6.35	mm	
Screw L/D Ratio	18.0:1.0 to 20.0:1.0		
Screw Compression Ratio	2.0 : 1.0 - 3.0 : 1.0		

Injection instructions

Injection speed: 2 in/sec Injection pressure: medium to maximum

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