

LNP™ STAT-LOY™ PF303 compound

Polyamide 6

SABIC Innovative Plastics

Message:

LNP STAT-LOY PF303 is a Nylon 6 base resin containing 15% Glass Fiber. Added features of this grade includes: Antistat.

Also known as: LNP* STAT-LOY* Compound PF-15

Product reorder name: PF303

General Information			
Filler / Reinforcement	Glass Fiber, 15% Filler by Weight		
Additive	Antistatic		
Features	Antistatic		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.25	g/cm ³	ASTM D792
--	1.24	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.50 to 0.70	%	
Across Flow : 24 hr	0.90 to 2.0	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	6.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5620	MPa	ASTM D638
--	4750	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	82.0	MPa	ASTM D638
Yield	72.0	MPa	ISO 527-2/5
Break ³	74.0	MPa	ASTM D638
Break	68.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.3	%	ASTM D638
Yield	2.4	%	ISO 527-2/5
Break ⁵	2.4	%	ASTM D638
Break	2.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4250	MPa	ASTM D790
-- ⁷	4260	MPa	ISO 178
Flexural Stress			
--	103	MPa	ISO 178

Yield, 50.0 mm Span ⁸	121	MPa	ASTM D790
Break, 50.0 mm Span ⁹	120	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	93	J/m	ASTM D256
23°C ¹⁰	9.3	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	750	J/m	ASTM D4812
23°C ¹¹	44	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.5	J	ASTM D3763
--	2.90	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	207	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	204	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	188	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	181	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.1E-5	cm/cm/°C	
Transverse : -30 to 30°C	1.4E-4	cm/cm/°C	
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	9.0 to 11	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	266 to 277	°C	
Front Temperature	277 to 288	°C	
Processing (Melt) Temp	266 to 277	°C	
Mold Temperature	82.2 to 93.3	°C	
Back Pressure	0.344 to 0.689	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		

8.	1.3 mm/min
9.	1.3 mm/min
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	80*10*4 mm

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