

LNP™ THERMOTUF™ VF004S compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOTUF VF004S is a compound based on Super Tough Nylon resin containing Glass Fiber. Added features of this material include: Heat Stabilized.

Also known as: LNP* THERMOTUF* Compound VF-1004 HS

Product reorder name: VF004S

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	heat stabilizer		
Features	Thermal Stability		
	Good toughness		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.21	g/cm³	ISO 1183
Molding Shrinkage - Flow	0.30 - 0.60	%	Internal method
Water Absorption (23°C, 24 hr)	0.70	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5800	MPa	ISO 527-2/1
Tensile Stress (Yield)	94.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.5	%	ISO 527-2/5
Flexural Stress ¹			ISO 178
-- ²	4500	MPa	ISO 178
-- ³	134	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ⁴ (23°C)	22	kJ/m²	ISO 180/1A
Unnotched Izod Impact Strength ⁵ (23°C)	55	kJ/m²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶			
0.45 MPa, unannealed, 64.0mm span	248	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 64.0mm span	235	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 60°C	3.8E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 60°C	1.7E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	

Suggested Max Moisture	0.15	%
Rear Temperature	260 - 271	°C
Middle Temperature	277 - 288	°C
Front Temperature	293 - 304	°C
Processing (Melt) Temp	282 - 293	°C
Mold Temperature	93.3 - 110	°C
Back Pressure	0.172 - 0.344	MPa
Screw Speed	30 - 60	rpm

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | Break |
| 3. | Yield |
| 4. | 80*10*4 |
| 5. | 80*10*4 |
| 6. | 80*10*4 mm |

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