

LNP™ THERMOCOMP™ IX04513C compound

Polyamide 612
SABIC Innovative Plastics

Message:

LNP THERMOCOMP* IX04513C is a compound based on Nylon 6/12 resin containing Glass Fiber. Added features of this material include: Clean Compounding System.
Also known as: LNP* THERMOCOMP* Compound PDX-I-04513 CCS
Product reorder name: IX04513C

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Features	Low (to None) Ion Content		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.20 - 0.40	%	ASTM D955
Transverse flow: 24 hours	0.90 - 1.1	%	ASTM D955
Vertical flow direction: 24 hours	0.90 - 1.1	%	ISO 294-4
Flow direction: 24 hours	0.20 - 0.40	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.15	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.21	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8840	MPa	ASTM D638
--	8290	MPa	ISO 527-2/1
Tensile Strength			
Fracture	131	MPa	ASTM D638
Fracture	128	MPa	ISO 527-2
Tensile Elongation			
Fracture	2.3	%	ASTM D638
Fracture	2.2	%	ISO 527-2
Flexural Modulus			
--	8080	MPa	ASTM D790
--	7110	MPa	ISO 178
Flexural Strength			
--	204	MPa	ASTM D790
--	187	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	69	J/m	ASTM D256
23°C ²	6.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	690	J/m	ASTM D4812
23°C ³	42	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	10.2	J	ASTM D3763
--	3.06	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, unannealed, 3.20mm	197	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁴	192	°C	ISO 75-2/Af
Linear thermal expansion coefficient			
Flow: -40 to 40°C	4.1E-5	cm/cm/°C	ASTM E831
Flow: -40 to 40°C	4.0E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	7.3E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 - 0.20	%	
Rear Temperature	254 - 266	°C	
Middle Temperature	260 - 271	°C	
Front Temperature	271 - 282	°C	
Processing (Melt) Temp	271 - 277	°C	
Mold Temperature	65.6 - 93.3	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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