

LNP™ THERMOTUF™ WF002I compound

Polybutylene Terephthalate

SABIC Innovative Plastics

Message:

LNP THERMOTUF WF006I is a compound based on PBT resin containing 10% Glass Fiber. Added feature of this grade is: High Impact.

Also known as: LNP* THERMOTUF* Compound WF-1002 HI

Product reorder name: WF002I

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Features	High Impact Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	1.0 to 3.0	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.070	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3770	MPa	ASTM D638
--	3680	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	64.0	MPa	ASTM D638
Yield	62.0	MPa	ISO 527-2/5
Break ³	55.0	MPa	ASTM D638
Break	60.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	3.4	%	ASTM D638
Yield	3.4	%	ISO 527-2/5
Break ⁵	4.4	%	ASTM D638
Break	4.3	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	3320	MPa	ASTM D790
-- ⁷	3270	MPa	ISO 178
Flexural Stress			
--	102	MPa	ISO 178
Yield, 50.0 mm Span ⁸	102	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C ⁹	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	710	J/m	ASTM D4812
23°C ¹⁰	40	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	6.60	J	ASTM D3763
--	1.74	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	214	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	207	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	178	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	161	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	7.2E-5	cm/cm/°C	
Transverse : -30 to 30°C	1.1E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.050	%	
Rear Temperature	221 to 232	°C	
Middle Temperature	243 to 254	°C	
Front Temperature	260 to 271	°C	
Processing (Melt) Temp	238 to 266	°C	
Mold Temperature	82.2 to 98.9	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	5.0 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.	80*10*4		
10.	80*10*4		
11.	80*10*4 mm		
12.	80*10*4 mm		

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