

LNP™ THERMOCOMP™ HB006 compound

Polyamide 11

SABIC Innovative Plastics

Message:

LNP THERMOCOMP HB006 is a compound based on Nylon 11 resin containing 30% Glass Bead.

Also known as: LNP* THERMOCOMP* Compound HB-1006

Product reorder name: HB006

General Information			
Filler / Reinforcement	Glass Bead,30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.27	g/cm ³	ASTM D792
--	1.24	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 24 hr	1.7	%	
Across Flow : 24 hr	1.5	%	
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1970	MPa	ASTM D638
--	2090	MPa	ISO 527-2/1
Tensile Strength			
Yield	45.5	MPa	ASTM D638
Yield	46.0	MPa	ISO 527-2
Break	43.4	MPa	ASTM D638
Break	41.0	MPa	ISO 527-2
Tensile Elongation			
Yield	23	%	ASTM D638
Yield	24	%	ISO 527-2
Break	20	%	ASTM D638
Break	43	%	ISO 527-2
Flexural Modulus			
--	1920	MPa	ASTM D790
--	3000	MPa	ISO 178
Flexural Strength			
--	55.2	MPa	ASTM D790
--	58.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	85	J/m	ASTM D256
23°C ²	6.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1500	J/m	ASTM D4812
23°C ³	170	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Energy at Peak Load)	33.3	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	145	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	151	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	46.1	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	47.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	199 to 210	°C	
Middle Temperature	232 to 243	°C	
Front Temperature	260 to 271	°C	
Processing (Melt) Temp	227 to 260	°C	
Mold Temperature	43.3 to 54.4	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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