

LNP™ THERMOCOMP™ XF006S compound

Polyamide

SABIC Innovative Plastics

Message:

LNP THERMOCOMP XF006S is a compound based on Amorphous Nylon containing 30% Glass Fiber. Added feature of th is grade is: Heat Stabilized.

Also known as: LNP* THERMOCOMP* Compound XF-1006 HS

Product reorder name: XF006S

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer		
Features	Amorphous		
	Heat Stabilized		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.36	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	7.0E-3 to 9.0E-3	%	
Across Flow : 24 hr	0.20 to 0.40	%	
Water Absorption			
24 hr, 50% RH	0.22	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.28	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	9660	MPa	ASTM D638
--	9030	MPa	ISO 527-2/1
Tensile Strength			
Break ²	138	MPa	ASTM D638
Break	141	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.6	%	ASTM D638
Break	2.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	9060	MPa	ASTM D790
-- ⁵	8920	MPa	ISO 178
Flexural Stress			
--	214	MPa	ISO 178
Yield, 50.0 mm Span ⁶	209	MPa	ASTM D790
Break, 50.0 mm Span ⁷	208	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	57	J/m	ASTM D256
23°C ⁸	5.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	630	J/m	ASTM D4812
23°C ⁹	38	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	11.5	J	ASTM D3763
--	3.30	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	142	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	144	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	138	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	137	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	4.4E-5	cm/cm/°C	
Transverse : -30 to 30°C	3.5E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	100 to 120	°C	
Drying Time	6.0 to 12	hr	
Suggested Max Moisture	0.10	%	
Rear Temperature	260 to 270	°C	
Middle Temperature	270 to 290	°C	
Front Temperature	290 to 300	°C	
Processing (Melt) Temp	260 to 300	°C	
Mold Temperature	50.0 to 100	°C	
Back Pressure	0.170 to 0.340	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.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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