

LNP™ THERMOCOMP™ PF006S compound

Polyamide 6

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* PF006S is a compound based on Nylon 6 resin containing 30% Glass Fiber. Added features of this material include: Heat Stabilized.

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

Product reorder name: PF006S

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.37	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.20 to 0.50	%	ASTM D955
Across Flow : 24 hr	1.0 to 1.2	%	ASTM D955, ISO 294-4
Flow : 24 hr	0.17 to 0.50	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.86	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.5	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8760	MPa	ASTM D638
--	8580	MPa	ISO 527-2/1
Tensile Strength			
Break	130	MPa	ASTM D638
Break	128	MPa	ISO 527-2
Tensile Elongation			
Break	2.8	%	ASTM D638
Break	2.9	%	ISO 527-2
Flexural Modulus			
--	6960	MPa	ASTM D790
--	7970	MPa	ISO 178
Flexural Strength			
--	201	MPa	ASTM D790
--	204	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	120	J/m	ASTM D256

23°C ²	8.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	850	J/m	ASTM D4812
23°C ³	55	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	9.00	J	ASTM D3763
--	3.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	219	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	206	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	203	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	3.1E-5	cm/cm/°C	
Transverse : -40 to 40°C	6.7E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	266 to 277	°C	
Front Temperature	277 to 288	°C	
Processing (Melt) Temp	266 to 277	°C	
Mold Temperature	82.2 to 93.3	°C	
Back Pressure	0.344 to 0.689	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		

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