

LNP™ THERMOCOMP™ QF0069 compound

Polyamide 610

SABIC Innovative Plastics

Message:

LNP THERMOCOMP QF0069 is a compound based on Nylon 6/10 resin containing 30% Glass Fiber. Added features of this material include: Flame Retardant.

Also known as: LNP* THERMOCOMP* Compound QF-1006 FR-1

Product reorder name: QF0069

General Information			
UL YellowCard	E121562-101344701		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.20 to 0.40	%	ASTM D955
Across Flow : 24 hr	0.80 to 1.0	%	ASTM D955
Across Flow : 24 hr	0.86	%	ISO 294-4
Flow : 24 hr	0.29	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	11000	MPa	ASTM D638
--	11000	MPa	ISO 527-2/1
Tensile Strength			
Yield	150	MPa	ASTM D638
Yield	145	MPa	ISO 527-2
Break	150	MPa	ASTM D638
Break	145	MPa	ISO 527-2
Tensile Elongation			
Yield	2.0	%	ASTM D638
Yield	1.8	%	ISO 527-2
Break	2.0	%	ASTM D638
Break	1.8	%	ISO 527-2
Flexural Modulus			
--	9650	MPa	ASTM D790
--	9000	MPa	ISO 178
Flexural Strength			
--	200	MPa	ASTM D790

--	197	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	64	J/m	ASTM D256
23°C ²	6.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	600	J/m	ASTM D4812
23°C ³	37	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	9.50	J	ASTM D3763
--	2.10	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	220	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	218	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	201	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	197	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	6.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	4.0E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 to 0.20	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	260 to 271	°C	
Front Temperature	271 to 282	°C	
Processing (Melt) Temp	271 to 277	°C	
Mold Temperature	82.2 to 93.3	°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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