

LNP™ THERMOCOMP™ HF006EU compound

Polyamide 11

SABIC Innovative Plastics Europe

Message:

LNP THERMOCOMP HF006EU is a compound based on PA 11 resin containing Glass Fiber. Added features include: Easy Molding, UV-Stabilized.

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	UV Stabilizer		
Features	Good Moldability		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.10 to 0.30	%	Internal Method
Water Absorption (23°C, 24 hr)	0.18	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7100	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	117	MPa	
Break	116	MPa	
Tensile Strain (Yield)	6.0	%	ISO 527-2/5
Flexural Modulus ¹	5600	MPa	ISO 178
Flexural Stress	169	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	23	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	95	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	186	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	173	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.4E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.5E-4	cm/cm/°C	
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.	2.0 mm/min	
2.	80*10*4	
3.	80*10*4	
4.	80*10*4 mm	

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