

LNP™ THERMOTUF™ PF006I compound

Polyamide 6

SABIC Innovative Plastics

Message:

LNP THERMOTUF* PF006I is a compound based on Nylon 6 resin containing 30% Glass Fiber. Added features of this material include: High Impact.

Also known as: LNP* THERMOTUF* Compound PF-1006 HI

Product reorder name: PF006I

General Information			
UL YellowCard	E121562-101281582		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	High Impact Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.35	g/cm ³	ASTM D792
--	1.37	g/cm ³	ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.10 to 0.30	%	ASTM D955
Across Flow : 24 hr	0.90 to 2.0	%	ASTM D955
Across Flow : 24 hr	0.62 to 0.67	%	ISO 294-4
Flow : 24 hr	0.11 to 0.30	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.83	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.83	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	16200	MPa	ASTM D638
--	9650	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	50.0	MPa	ASTM D638
Yield	35.0	MPa	ISO 527-2/5
Break ³	97.4	MPa	ASTM D638
Break	99.0	MPa	ISO 527-2/5
Tensile Elongation ⁴ (Break)	8.2	%	ASTM D638
Flexural Modulus ⁵ (50.0 mm Span)	6830	MPa	ASTM D790
Flexural Strength ⁶ (Break, 50.0 mm Span)	158	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	110	J/m	ASTM D256
23°C ⁷	11	kJ/m ²	ISO 180/1A

Unnotched Izod Impact			
23°C	730	J/m	ASTM D4812
23°C ⁸	54	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	16.0	J	ASTM D3763
--	4.98	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	139	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	141	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	137	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	135	°C	ISO 75-2/Af
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm, Testing by SABIC)	HB		UL 94
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.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	1.3 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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