OnForce™ LFT LF6600-5016 NATURAL FD

Polyamide 66

PolyOne Corporation

Message:

Polyvan's long fiber thermoplastic polymers are used in situations where high hardness and good impact resistance are required, such as metal substitution or other structural applications. These products exhibit enhanced physical and mechanical properties compared to staple fiber products. Its advantages include improved impact strength, elasticity and material strength in different temperature ranges. In addition, compared with traditional high-filled short fiber products, long fiber thermoplastic polymers show improved properties in terms of creep and fatigue resistance, improved dimensional stability and unique surface finish.

General Information			
Filler / Reinforcement	Long glass fiber		
Forms	Particle		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.60	g/cm³	ISO 1183
Molding Shrinkage [1]	0.30	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	15000	MPa	ISO 527-2
Tensile Stress (Break)	270	MPa	ISO 527-2
Tensile Strain (Break)	2.0	%	ISO 527-2
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress	350	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	25	kJ/m²	ISO 179
Charpy Unnotched Impact Strength	90	kJ/m²	ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
1.8 MPa, not annealed	255	°C	ISO 75-2/A
8.0 MPa, not annealed	241	°C	ISO 75-2/C
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0	°C	
Drying Time	4.0	hr	
Processing (Melt) Temp	290 - 320	°C	
Mold Temperature	90.0	°C	
Injection Rate	Slow-Moderate		
Back Pressure	5.00	MPa	

Injection instructions
LFT compounds can be processed using equipment similar to that used for short fiber products. The mechanical properties of finished parts depend greatly on the length of the fibers in the molded part; therefore processing conditions must be set carefully in order to minimize fiber breakage. A "low shear process" is advised, with low back pressure, low screw speed and low-to-medium injection speed.
NOTE

1.	Measured on a tensile specimen. Actual mold shrinkage values are highly dependant on part geometry, mold configuration, and processing conditions.

Recommended distributors for this material

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