

LNP™ THERMOCOMP™ PFB91S compound

Polyamide 6
SABIC Innovative Plastics

Message:

LNP THERMOCOMP PFB91S is a compound based on Nylon 6 resin containing Proprietary Filler(s).
Also known as: LNP* THERMOCOMP* Compound PDX-P-00461
Product reorder name: PFB91S

General Information			
Filler / Reinforcement	Proprietary		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm ³	ASTM D792
Molding Shrinkage - Flow (24 hr)	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	7490	MPa	ASTM D638
Tensile Strength			ASTM D638
Break	62.1	MPa	
Break ²	62.1	MPa	
Tensile Elongation			ASTM D638
Break	2.7	%	
Break ³	2.7	%	
Flexural Modulus			ASTM D790
--	6050	MPa	
50.0 mm Span ⁴	6050	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	37	J/m	ASTM D256
Unnotched Izod Impact (23°C)	280	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	163	°C	ASTM D648
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.	1.3 mm/min	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
Phone: +86 13424755533
Email: sales@su-jiao.com
No. 215, Lianhe North Road, Fengxian District, Shanghai, China

