

LNP™ THERMOCOMP™ IF006 compound

Polyamide 612

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* IF006 is a compound based on nylon 6/12 resin containing glass fibre

Also known as: LNP* THERMOCOMP* Compound IF-1006

Product reorder name: IF006

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
RoHS Compliance	RoHS compliance		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.30 - 0.40	%	Internal method
Water Absorption (23°C, 24 hr)	0.25	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	7800	MPa	ISO 527-2/1
Tensile Stress (Yield)	120	MPa	ISO 527-2/5
Tensile Strain (Break)	2.1	%	ISO 527-2/5
Flexural Modulus ¹	6050	MPa	ISO 178
Flexural Stress	185	MPa	ISO 178
Flexural Strain at Break ²	4.2	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact ³ (23°C)	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, unannealed, 64.0mm span	209	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 64.0mm span	188	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ISO 11359-2
Flow: 23 to 60°C	3.9E-5	cm/cm/°C	ISO 11359-2
Lateral: 23 to 60°C	1.6E-4	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 - 0.20	%	
Rear Temperature	254 - 266	°C	
Middle Temperature	260 - 271	°C	
Front Temperature	271 - 282	°C	
Processing (Melt) Temp	271 - 277	°C	

Mold Temperature	65.6 - 93.3	°C
Back Pressure	0.172 - 0.344	MPa
Screw Speed	30 - 60	rpm

NOTE		
1.	2.0 mm/min	
2.	2 mm/min	
3.	80*10*4	
4.	80*10*4	
5.	80*10*4 mm	

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