

LNP™ THERMOCOMP™ PF00ASXS

compound

Polyamide 6

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* PF00ASXS is a compound based on Nylon 6 resin containing 50% Glass Fiber. Added features of this material include: Heat Stabilized.

Also known as: LNP* THERMOCOMP* Compound PF-100-10 HS

Product reorder name: PF00ASXS

General Information			
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.10 to 0.30	%	ASTM D955, ISO 294-4
Across Flow : 24 hr	0.60 to 0.70	%	ASTM D955
Across Flow : 24 hr	0.60 to 0.80	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.83	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.97	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	17100	MPa	ASTM D638
--	17300	MPa	ISO 527-2/1
Tensile Strength			
Break	214	MPa	ASTM D638
Break	241	MPa	ISO 527-2
Tensile Elongation			
Break	2.8	%	ASTM D638
Break	3.0	%	ISO 527-2
Flexural Modulus			
--	12300	MPa	ASTM D790
--	12400	MPa	ISO 178
Flexural Strength			
--	329	MPa	ASTM D790
--	318	MPa	ISO 178

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	180	J/m	ASTM D256
23°C ²	19	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	95	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	18.3	J	ASTM D3763
--	22.5	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	198	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	210	°C	ISO 75-2/Af
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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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