

LNP™ THERMOCOMP™ SF00A compound

Polyamide 12

SABIC Innovative Plastics

Message:

Glass filled Nylon 12

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.20 - 0.40	%	ASTM D955
Transverse flow: 24 hours	0.80 - 1.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	12800	MPa	ASTM D638
--	12300	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	121	MPa	ASTM D638
Yield	113	MPa	ISO 527-2/5
Fracture ³	121	MPa	ASTM D638
Fracture	113	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.8	%	ASTM D638
Yield	1.5	%	ISO 527-2/5
Fracture ⁵	1.8	%	ASTM D638
Fracture	1.5	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	8930	MPa	ASTM D790
-- ⁷	11.0	MPa	ISO 178
Flexural Strength ⁸			
Yield, 50.0mm span	148	MPa	ASTM D790
Fracture, 50.0mm span	143	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	97	J/m	ASTM D256
23°C ⁹	1.8	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	580	J/m	ASTM D4812

23°C ¹⁰	31	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy	16.0	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	176	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	166	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹¹	176	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 - 0.20	%	
Rear Temperature	216 - 227	°C	
Middle Temperature	221 - 232	°C	
Front Temperature	227 - 238	°C	
Processing (Melt) Temp	227 - 238	°C	
Mold Temperature	71.1 - 82.2	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	Type 1, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4		
10.	80*10*4		
11.	80*10*4 mm		

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