

LNP™ THERMOCOMP™ QF007 compound

Polyamide 610

SABIC Innovative Plastics

Message:

LNP THERMOCOMP QF007 is a compound based on Nylon 6/10 resin containing 35% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound QF-1007

Product reorder name: QF007

General Information			
Filler / Reinforcement	Glass Fiber,35% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.33	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.10 to 0.40	%	
Across Flow : 24 hr	0.90 to 2.0	%	
Water Absorption			
24 hr, 50% RH	0.20	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.37	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	9980	MPa	ASTM D638
--	9610	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	156	MPa	ASTM D638
Yield	157	MPa	ISO 527-2/5
Break	177	MPa	ASTM D638
Break ³	156	MPa	ASTM D638
Break	157	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.4	%	ASTM D638
Yield	2.5	%	ISO 527-2/5
Break ⁵	2.4	%	ASTM D638
Break	2.5	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	8320	MPa	ASTM D790
--	8910	MPa	ASTM D790
-- ⁷	7940	MPa	ISO 178
Flexural Strength			
--	269	MPa	ASTM D790
--	227	MPa	ISO 178

Yield, 50.0 mm Span ⁸	239	MPa	ASTM D790
Break, 50.0 mm Span ⁹	238	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	120	J/m	ASTM D256
23°C ¹⁰	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1100	J/m	ASTM D4812
23°C ¹¹	66	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.6	J	ASTM D3763
--	4.10	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	222	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	219	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	214	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	203	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.5E-5	cm/cm/°C	
Transverse : -30 to 30°C	1.1E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 to 0.20	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	260 to 271	°C	
Front Temperature	271 to 282	°C	
Processing (Melt) Temp	271 to 277	°C	
Mold Temperature	82.2 to 93.3	°C	
Back Pressure	0.172 to 0.344	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.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	1.3 mm/min		

10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	80*10*4 mm

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