

LNP™ THERMOCOMP™ PFB55 compound

Polyamide 6

SABIC Innovative Plastics Europe

Message:

LNP THERMOCOMP PFB55 is a compound based on PA 6 resin containing Glass Bead, Glass Fiber.

General Information			
Filler / Reinforcement	Glass Bead\Glass Fiber		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.56	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.20 to 0.40	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	10900	MPa	ISO 527-2/1
Tensile Stress (Yield)	155	MPa	ISO 527-2/5
Tensile Strain (Break)	2.7	%	ISO 527-2/5
Flexural Modulus ¹	10000	MPa	ISO 178
Flexural Stress	229	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	50	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	204	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.9E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.5E-5	cm/cm/°C	
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.	2.0 mm/min
2.	80*10*4
3.	80*10*4
4.	80*10*4 mm

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