

LNP™ THERMOCOMP™ TF006 compound

Polyurethane

SABIC Innovative Plastics

Message:

LNP THERMOCOMP TF006 is a compound based on Polyurethane containing 30% Glass Fiber.

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

Product reorder name: TF006

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.47	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.10 to 0.40	%	ASTM D955
Across Flow : 24 hr	0.50 to 0.80	%	ASTM D955
Across Flow : 24 hr	0.40	%	ISO 294-4
Flow : 24 hr	0.15	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.36	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.50	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	1480	MPa	ASTM D638
--	1800	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	50.0	MPa	ASTM D638
Yield	51.0	MPa	ISO 527-2/5
Break ³	49.9	MPa	ASTM D638
Break	51.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	16	%	ASTM D638
Yield	16	%	ISO 527-2/5
Break ⁵	16	%	ASTM D638
Break	16	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	1700	MPa	ASTM D790
-- ⁷	2190	MPa	ISO 178
Flexural Strength ⁸ (Break, 50.0 mm Span)	58.0	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	510	J/m	ASTM D256
23°C ⁹	41	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	No Break		ASTM D4812
23°C ¹⁰	130	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	19.5	J	ASTM D3763
--	17.6	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	167	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	167	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	78.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	85.0	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	2.7E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	2.8E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	1.3E-4	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	93.0 to 104	°C	
Drying Time	2.0	hr	
Suggested Max Moisture	0.030	%	
Suggested Shot Size	40 to 80	%	
Rear Temperature	193 to 210	°C	
Middle Temperature	193 to 216	°C	
Front Temperature	199 to 221	°C	
Nozzle Temperature	204 to 227	°C	
Processing (Melt) Temp	210	°C	
Mold Temperature	16.0 to 43.0	°C	
Back Pressure	0.170 to 0.340	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.	80*10*4		
10.	80*10*4		

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

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