## OnForce<sup>™</sup> LFT LF6600-5013 Grey

## Polyamide 66

PolyOne Corporation

## Message:

Polyvan's long fiber thermoplastic polymers are used in situations where high hardness and good impact resistance are required, such as metal substitution or other structural applications. These products exhibit enhanced physical and mechanical properties compared to staple fiber products. Its advantages include improved impact strength, elasticity and material strength in different temperature ranges. In addition, compared with traditional high-filled short fiber products, long fiber thermoplastic polymers show improved properties in terms of creep and fatigue resistance, improved dimensional stability and unique surface finish.

General Information			
Filler / Reinforcement	Long glass fiber		
Appearance	Grey		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Density	1.68	g/cm³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	22000	MPa	ISO 527-2
Tensile Stress (Break)	240	MPa	ISO 527-2
Tensile Strain (Break)	1.6	%	ISO 527-2
Flexural Modulus	15000	MPa	ISO 178
Flexural Stress	300	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Impact Charpy Notched Impact Strength	Nominal Value	Unit kJ/m²	Test Method ISO 179
Charpy Notched Impact Strength	16	kJ/m²	ISO 179
Charpy Notched Impact Strength Charpy Unnotched Impact Strength	16 60	kJ/m² kJ/m²	ISO 179 ISO 179
Charpy Notched Impact Strength Charpy Unnotched Impact Strength Dart Drop Impact	16 60 113	kJ/m² kJ/m² J	ISO 179 ISO 179
Charpy Notched Impact Strength Charpy Unnotched Impact Strength Dart Drop Impact Injection	16 60 113 Nominal Value	kJ/m² kJ/m² J Unit	ISO 179 ISO 179
Charpy Notched Impact Strength Charpy Unnotched Impact Strength Dart Drop Impact Injection Drying Temperature	16 60 113 Nominal Value 80.0	kJ/m² kJ/m² J Unit °C	ISO 179 ISO 179
Charpy Notched Impact Strength Charpy Unnotched Impact Strength Dart Drop Impact Injection Drying Temperature Drying Time	16   60   113   Nominal Value   80.0   4.0	kJ/m² kJ/m² J Unit °C hr	ISO 179 ISO 179
Charpy Notched Impact Strength Charpy Unnotched Impact Strength Dart Drop Impact <b>Injection</b> Drying Temperature Drying Time Processing (Melt) Temp	16   60   113   Nominal Value   80.0   4.0   290 - 320	kJ/m² kJ/m² J Unit °C hr °C	ISO 179 ISO 179
Charpy Notched Impact Strength Charpy Unnotched Impact Strength Dart Drop Impact Injection Drying Temperature Drying Time Processing (Melt) Temp Mold Temperature	16   60   113   Nominal Value   80.0   4.0   290 - 320   90.0	kJ/m² kJ/m² J Unit °C hr °C	ISO 179 ISO 179

LFT compounds can be processed using equipment similar to that used for short fiber products. The mechanical properties of finished parts depend greatly on the length of the fibers in the molded part; therefore processing conditions must be set carefully in order to minimize fiber breakage. A "low shear process" is advised, with low back pressure, low screw speed and low-to-medium injection speed.

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