

LNP™ COLORCOMP™ R1000 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP* COLORCOMP* R1000 is an unfilled Nylon 66.

Also known as: LNP* COLORCOMP* Compound R-1000

Product reorder name: R1000

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Flow	1.2	%	
Across Flow	1.4	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3000	MPa	ISO 527-2/1
Tensile Stress (Yield)	79.9	MPa	ISO 527-2/5
Tensile Strain			ISO 527-2/5
Yield	11	%	
Break	45	%	
Flexural Modulus ¹	2900	MPa	ISO 178
Flexural Stress	33.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/2C
-30°C	6.0	kJ/m ²	
23°C	6.0	kJ/m ²	
Charpy Unnotched Impact Strength ²			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength ³ (23°C)	5.5	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	200	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	70.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	266 to 277	°C	
Middle Temperature	282 to 293	°C	

Front Temperature	293 to 304	°C
Processing (Melt) Temp	277 to 288	°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.	2.0 mm/min	
2.	80*10*4mm, Cut	
3.	80*10*4	
4.	80*10*4 mm	

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