

LNP™ THERMOCOMP™ IX04513C compound

Polyamide 612

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* IX04513C is a compound based on Nylon 6/12 resin containing Glass Fiber. Added features of this material include: Clean Compounding System.

Also known as: LNP* THERMOCOMP* Compound PDX-I-04513 CCS

Product reorder name: IX04513C

General Information			
Filler / Reinforcement	Glass Fiber		
Features	Low (to None) Ion Content		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 24 hr	0.20 to 0.40	%	
Across Flow : 24 hr	0.90 to 1.1	%	
Water Absorption			
24 hr, 50% RH	0.15	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.21	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8840	MPa	ASTM D638
--	8290	MPa	ISO 527-2/1
Tensile Strength			
Break	131	MPa	ASTM D638
Break	128	MPa	ISO 527-2
Tensile Elongation			
Break	2.3	%	ASTM D638
Break	2.2	%	ISO 527-2
Flexural Modulus			
--	8080	MPa	ASTM D790
--	7110	MPa	ISO 178
Flexural Strength			
--	204	MPa	ASTM D790
--	187	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	69	J/m	ASTM D256
23°C ²	6.4	kJ/m ²	ISO 180/1A

Unnotched Izod Impact			
23°C	690	J/m	ASTM D4812
23°C ³	42	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	10.2	J	ASTM D3763
--	3.06	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	197	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	192	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	4.1E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	4.0E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	7.3E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 to 0.20	%	
Rear Temperature	254 to 266	°C	
Middle Temperature	260 to 271	°C	
Front Temperature	271 to 282	°C	
Processing (Melt) Temp	271 to 277	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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