

LNP™ THERMOCOMP™ QF00A compound

Polyamide 610

SABIC Innovative Plastics

Message:

LNP THERMOCOMP QF00A is a compound based on Nylon 6/10 containing 50% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound QF-100-10

Product reorder name: QF00A

General Information			
Filler / Reinforcement	Glass Fiber,50% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.18 to 0.20	%	
Across Flow : 24 hr	0.50 to 1.5	%	
Water Absorption			
24 hr, 50% RH	0.21	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.28	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	18700	MPa	ASTM D638
--	15500	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	181	MPa	ASTM D638
Yield	182	MPa	ISO 527-2/5
Break ³	181	MPa	ASTM D638
Break	182	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.6	%	ASTM D638
Yield	2.3	%	ISO 527-2/5
Break ⁵	2.6	%	ASTM D638
Break	2.3	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	11400	MPa	ASTM D790
-- ⁷	12900	MPa	ISO 178
Flexural Strength ⁸			ASTM D790
Yield, 50.0 mm Span	280	MPa	
Break, 50.0 mm Span	285	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	160	J/m	ASTM D256
23°C ⁹	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1300	J/m	ASTM D4812
23°C ¹⁰	75	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	221	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	220	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	213	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	206	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 to 0.20	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	260 to 271	°C	
Front Temperature	271 to 282	°C	
Processing (Melt) Temp	271 to 277	°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.	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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