

LNP™ THERMOCOMP™ PFW64 compound

Polyamide 6

SABIC Innovative Plastics

Message:

LNP THERMOCOMP PFW64 is a compound based on Nylon 6 resin containing 20% Glass Fiber, 30% Wollastonite.

Also known as: LNP* THERMOCOMP* Compound PFM-3264

Product reorder name: PFW64

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
	Wollastonite (CaSiO3),30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.63	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.50	%	
Across Flow : 24 hr	0.80 to 1.0	%	
Water Absorption			
24 hr, 50% RH	0.75	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.98	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	12300	MPa	ASTM D638
--	11500	MPa	ISO 527-2/1
Tensile Strength			
Break ²	135	MPa	ASTM D638
Break	133	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.0	%	ASTM D638
Break	2.0	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	9230	MPa	ASTM D790
-- ⁵	10600	MPa	ISO 178
Flexural Stress			
--	195	MPa	ISO 178
Break, 50.0 mm Span ⁶	169	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁷ (23°C)	5.6	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	810	J/m	ASTM D4812

23°C ⁸	39	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	7.40	J	ASTM D3763
--	2.90	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	216	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	218	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	203	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	201	°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	249 to 260	°C	
Middle Temperature	266 to 277	°C	
Front Temperature	277 to 288	°C	
Processing (Melt) Temp	266 to 277	°C	
Mold Temperature	82.2 to 93.3	°C	
Back Pressure	0.344 to 0.689	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.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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