LNP™ THERMOCOMP™ Compound IF00C

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound IF-100-12
Product reorder name: IF00C

LNP THERMOCOMP IF00C is a compound based on Nylon 6/12 resin containing 60% Glass Fiber.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	207	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 5 mm/min	21440	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	311	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	18500	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	202	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.9	%	ISO 527
Tensile Modulus, 1 mm/min	20070	MPa	ISO 527
Flexural Stress	306	MPa	ISO 178
Flexural Modulus, 2 mm/min	18240	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1050	J/m	ASTM D 4812
Izod Impact, notched, 23°C	137	J/m	ASTM D 256
Multiaxial Impact	3	J	ISO 6603
Instrumented Impact Total Energy, 23°C	10	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	635	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	13	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	215	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	205	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.2E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	5.3E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	214	°C	ISO 75/Bf

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.
(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
(4) Internal measurements according to UL standards.
(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	198	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.68	-	ASTM D 792
Density	1.67	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.2 - 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.6 - 0.8	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.13	%	ISO 62

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(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.12 - 0.2	%
Melt Temperature	270 - 275	°C
Front - Zone 3 Temperature	270 - 280	°C
Middle - Zone 2 Temperature	260 - 270	°C
Rear - Zone 1 Temperature	255 - 265	°C
Mold Temperature	65 - 95	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

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