

LNP* Thermotuf* Compound P1000E13

Americas: COMMERCIAL

Also known as: P-1000 HI 020
Product Reorder Name: P1000E13

High Impact Nylon 6 compound containing Impact Modifier.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, break	40	MPa	ISO 527
Tensile Strain, break	100	%	ISO 527
Tensile Modulus, 1 mm/min	1800	MPa	ISO 527
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	96	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	44	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	51	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Mold Shrinkage, flow, 24 hrs	1.9 - 2.1	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.9 - 2.1	%	ISO 294
Density	1.08	g/cm ³	ISO 1183

Source GMD, last updated:09/30/2004

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	255 - 265	°C
Front - Zone 3 Temperature	250 - 260	°C
Middle - Zone 2 Temperature	250 - 260	°C
Rear - Zone 1 Temperature	245 - 255	°C
Mold Temperature	55 - 95	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

Source GMD, last updated:09/30/2004

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(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.

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