

LNP* Thermocomp* Compound WF006SXC

Americas: COMMERCIAL

Also known as: LNP* Thermocomp* Compound WF-1006 HS WT9-029

Product reorder name: WF006SXC

LNP* Thermocomp* WF006SXC is a compound based on PBT containing Glass Fiber. Characteristic of this grade is: Heat Stabilized.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	930	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.7	%	ASTM D 638
Tensile Modulus, 5 mm/min	90000	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1390	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1380	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	81900	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	88	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.6	%	ISO 527
Tensile Modulus, 1 mm/min	8500	MPa	ISO 527
Flexural Stress	130	MPa	ISO 178
Flexural Modulus, 2 mm/min	7820	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	36	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Multiaxial Impact	10	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	50	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10*4 +23°C	20	kJ/m ²	ISO 180/1U
Izod Impact, notched 80°10*4 +23°C	4	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	221	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	204	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.5	-	ASTM D 792
Density	1.56	g/cm ³	ASTM D 792

(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±176.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.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.04	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	1 - 3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	2 - 4	%	ASTM D 955

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	4	hrs
Maximum Moisture Content	0.05	%
Melt Temperature	240 - 265	°C
Front - Zone 3 Temperature	260 - 270	°C
Middle - Zone 2 Temperature	245 - 255	°C
Rear - Zone 1 Temperature	220 - 230	°C
Mold Temperature	80 - 100	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

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