LNP™ THERMOTUF™ Compound OF006I

Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound OF-1006 HI
Product reorder name: OF006I

LNP THERMOTUF™ OF006I is a compound based on PPS - Linear resin containing Glass Fiber. Added features of this material include: High Impact.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1460	kgf/cm²	ASTM D 638
Tensile Strain, break	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	110300	kgf/cm²	ASTM D 638
Flexural Stress	2110	kgf/cm²	ASTM D 790
Flexural Modulus	99800	kgf/cm²	ASTM D 790
Tensile Stress, break	139	MPa	ISO 527
Tensile Strain, break	2	%	ISO 527
Tensile Modulus, 1 mm/min	9820	MPa	ISO 527
Flexural Stress	212	MPa	ISO 178
Flexural Modulus	10060	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	79	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	17	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	136	cm-kgf	ASTM D 3763
Multiaxial Impact	49	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	50	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	16	kJ/m²	ISO 180/1A
PHYSICAL			
Density	1.486	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.04	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.7	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.23	%	ISO 294

(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
PHYSICAL			
Mold Shrinkage, xflow, 24 hrs (5)	0.67	%	ISO 294
Density	1.48	g/cm³	ISO 1183

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4	hrs
Melt Temperature	315 - 320	°C
Front - Zone 3 Temperature	330 - 345	°C
Middle - Zone 2 Temperature	320 - 330	°C
Rear - Zone 1 Temperature	305 - 315	°C
Mold Temperature	140 - 165	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

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