LNP™ THERMOTUF™ COMPOUND R1000I

R-1000 HI

DESCRIPTION

LNP THERMOTUF R1000I compound is based on Nylon 6/6 resin containing Impact Modifier.

GENERAL INFORMATION	
Features	Impact resistant, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polyamide 66 (Nylon 66)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	45	MPa	ISO 527
Tensile Strain, break	70	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress	50	MPa	ISO 178
Flexural Modulus	1400	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched 80*10*4 +23°C	98	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	55	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	65	°C	ISO 75/Af
PHYSICAL [1]			
Mold Shrinkage, flow, 24 hrs [2]	1.1 – 1.5	%	ISO 294
Density	1.09	g/cm³	ISO 1183
INJECTION MOLDING [3]			
Drying Temperature	80	°C	
Drying Time	4	Hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	265 – 275	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	255 – 265	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	60 – 100	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) 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.

(3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

DISCLAIMER