

# LNPTM COLORCOMPTM COMPOUND R1000

R-1000

## DESCRIPTION

LNP COLORCOMP R1000 compound is based on unfilled Nylon 6/6 resin.

GENERAL INFORMATION	
Features	Aesthetics/Visual effects, No PFAS intentionally added
Fillers	Unreinforced
Polymer Types	Polyamide 66 (Nylon 66)
Processing Techniques	Injection Molding
INDUSTRY	SUB INDUSTRY
Automotive	Automotive Interiors
Consumer	Home Decoration, Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Electrical and Electronics	Mobile Phone - Computer - Tablets

## TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
<b>MECHANICAL <sup>(1)</sup></b>			
Tensile Stress, yield, 5 mm/min	79	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	11	%	ISO 527
Tensile Strain, break, 5 mm/min	45	%	ISO 527
Tensile Modulus, 1 mm/min	2990	MPa	ISO 527
Flexural Stress	33	MPa	ISO 178
Flexural Modulus, 2 mm/min	2900	MPa	ISO 178
<b>IMPACT <sup>(1)</sup></b>			
Izod Impact, notched 80*10*4 +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A
Charpy Impact, notched, 23°C	6	kJ/m <sup>2</sup>	ISO 179/2C
Charpy Impact, notched, -30°C	6	kJ/m <sup>2</sup>	ISO 179/2C
<b>THERMAL <sup>(1)</sup></b>			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	200	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	70	°C	ISO 75/Af
<b>PHYSICAL <sup>(1)</sup></b>			
Mold Shrinkage, flow <sup>(2)</sup>	1.2	%	SABIC method
Mold Shrinkage, xflow <sup>(2)</sup>	1.4	%	SABIC method
Density	1.14	g/cm <sup>3</sup>	ISO 1183
<b>INJECTION MOLDING <sup>(3)</sup></b>			
Drying Temperature	80	°C	
Drying Time	4	Hrs	
Maximum Moisture Content	0.15 – 0.25	%	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	275 – 290	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	280 – 295	°C	
Rear - Zone 1 Temperature	265 – 275	°C	
Mold Temperature	80 – 95	°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.

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