LNP™ THERMOCOMP™ Compound WF006H

WF-1006 HC

DESCRIPTION

LNP THERMOCOMP WF006H compound is based on Polybutylene Terephthalate (PBT) resin containing 30% glass fiber. Added features of this grade include: Healthcare.

GENERAL INFORMATION	
Features	Healthcare/Formula lock, High stiffness/Strength, No PFAS intentionally added
Fillers	Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polybutylene Terephthalate (PBT)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Hygiene and Healthcare	Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing
Packaging	Industrial Packaging

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	119	MPa	ASTM D638
Tensile Strain, break	2.7	%	ASTM D638
Tensile Modulus, 50 mm/min	10440	MPa	ASTM D638
Flexural Stress	186	MPa	ASTM D790
Flexural Modulus	9440	MPa	ASTM D790
IMPACT [1]			
Izod Impact, unnotched, 23°C	713	J/m	ASTM D4812
Izod Impact, notched, 23°C	69	J/m	ASTM D256
THERMAL [1]			
HDT, 1.82 MPa, 3.2mm, unannealed	208	°C	ASTM D648
PHYSICAL [1]			
Density	1.62	g/cm³	ASTM D792
Mold Shrinkage, flow, 24 hrs [2]	0.6	%	ASTM D955
INJECTION MOLDING [3]			
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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