



LNP™ THERMOCOMP™ Compound PF008QS

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PF-1008 HS RM

Product reorder name: PF008QS

LNP THERMOCOMP™ PF008QS is a compound based on Nylon 6 resin containing 40% Glass Fiber. Added features of this material include: Heat Stabilized, Reduced Moisture.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1550	kgf/cm ²	ASTM D 638
Tensile Strain, break	3	%	ASTM D 638
Tensile Modulus, 50 mm/min	124400	kgf/cm ²	ASTM D 638
Flexural Stress	2490	kgf/cm ²	ASTM D 790
Flexural Modulus	97700	kgf/cm ²	ASTM D 790
Tensile Stress, break	165	MPa	ISO 527
Tensile Strain, break	3.4	%	ISO 527
Tensile Modulus, 1 mm/min	11600	MPa	ISO 527
Flexural Stress	262	MPa	ISO 178
Flexural Modulus	12000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	112	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	17	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	128	cm-kgf	ASTM D 3763
Multiaxial Impact	43	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	72	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	17	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	218	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	199	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.09E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.56E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.09E-05	1/°C	ISO 11359-2



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THERMAL			
CTE, -40°C to 40°C, xflow	5.56E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	201	°C	ISO 75/Af
PHYSICAL			
Density	1.354	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.31	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.7 - 0.9	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.3	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.7 - 0.9	%	ISO 294
Density	1.35	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.5	%	ISO 62



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	255 - 275	°C
Front - Zone 3 Temperature	265 - 275	°C
Middle - Zone 2 Temperature	255 - 265	°C
Rear - Zone 1 Temperature	250 - 260	°C
Mold Temperature	80 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	30 - 60	rpm