



LNP™ THERMOCOMP™ Compound PFB91S

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PDX-P-00461

Product reorder name: PFB91S

LNP THERMOCOMP PFB91S is a compound based on Nylon 6 resin containing Proprietary Filler(s).

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	630	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	630	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.7	%	ASTM D 638
Tensile Modulus, 50 mm/min	76400	kgf/cm ²	ASTM D 638
Flexural Modulus	61600	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	61600	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	28	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	163	°C	ASTM D 648
PHYSICAL			
Density	1.57	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.6	%	ASTM D 955



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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	265 - 275	°C
Front - Zone 3 Temperature	275 - 290	°C
Middle - Zone 2 Temperature	265 - 275	°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