+135-3858-6433 (GuangDong)
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LNP™ THERMOTUF™ Compound WF006I

Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound WF-1006 HI
Product reorder name: WF006I

LNP THERMOTUF™ WF006I is a compound based on PBT containing 30% Glass Fiber. Added features of this material include: High Impact.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1090	kgf/cm²	ASTM D 638
Tensile Stress, break	1080	kgf/cm²	ASTM D 638
Tensile Strain, yield	3.2	%	ASTM D 638
Tensile Strain, break	3.9	%	ASTM D 638
Tensile Modulus, 50 mm/min	91300	kgf/cm²	ASTM D 638
Flexural Stress	1770	kgf/cm²	ASTM D 790
Flexural Modulus	76600	kgf/cm²	ASTM D 790
Tensile Stress, yield	109	MPa	ISO 527
Tensile Strain, yield	2.1	%	ISO 527
Tensile Strain, break	2.8	%	ISO 527
Tensile Modulus, 1 mm/min	6520	MPa	ISO 527
Flexural Stress	181	MPa	ISO 178
Flexural Modulus	8620	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	101	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	19	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	175	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	64	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	20	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	210	°C	ASTM D 648
PHYSICAL			
Density	1.474	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.3	%	ASTM D 955

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TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, xflow, 24 hrs (5)	1.3	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.29	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.29	%	ISO 294
Density	1.47	g/cm³	ISO 1183

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
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
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm