



## LNP™ THERMOCOMP™ Compound OF006

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound OF-1006

Product reorder name: OF006

LNP THERMOCOMP OF006 is a compound based on Linear PPS containing 30% Glass Fiber.

TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, brk, Type I, 5 mm/min	1340	kgf/cm <sup>2</sup>	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	123300	kgf/cm <sup>2</sup>	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1730	kgf/cm <sup>2</sup>	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	101900	kgf/cm <sup>2</sup>	ASTM D 790
Tensile Stress, break, 5 mm/min	126	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	11960	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	175	MPa	ISO 178
Flexural Modulus, 2 mm/min	10520	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, unnotched, 23°C	39	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Multiaxial Impact	24	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	24	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL</b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	276	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	261	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.2E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	4.5E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	275	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	258	°C	ISO 75/Af



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TYPICAL PROPERTIES <sup>1</sup>	TYPICAL VALUE	Unit	Standard
<b>PHYSICAL</b>			
Density	1.57	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.02	%	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
Density	1.57	g/cm <sup>3</sup>	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.06	%	ISO 62



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<b>PROCESSING PARAMETERS</b>	<b>TYPICAL VALUE</b>	<b>Unit</b>
<b>Injection Molding</b>		
Drying Temperature	120 - 150	°C
Drying Time	4	hrs
Melt Temperature	315 - 320	°C
Front - Zone 3 Temperature	330 - 345	°C
Middle - Zone 2 Temperature	320 - 330	°C
Rear - Zone 1 Temperature	305 - 315	°C
Mold Temperature	140 - 165	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm