

LNP* Thermocomp* Compound PFW64

Americas: COMMERCIAL

Also known as: THERMOCOMP PFM-3264
Product Reorder Name: PFW64

LNP* Thermocomp* PFW64 is a compound based on Nylon 6 resin containing Glass Fiber and Wollastonite.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	135	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 50 mm/min	12300	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	169	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	9230	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	133	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2	%	ISO 527
Tensile Modulus, 1 mm/min	11480	MPa	ISO 527
Flexural Stress	195	MPa	ISO 178
Flexural Modulus, 2 mm/min	10620	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	807	J/m	ASTM D 4812
Izod Impact, notched, 23°C	0	J/m	ASTM D 256
Multiaxial Impact	2	J	ISO 6603
Instrumented Impact Total Energy, 23°C	7	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	39	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	216	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	203	°C	ASTM D 648
CTE, -30°C to 30°C, flow	3.37E+01	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	7.25E+01	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	218	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	201	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.63	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.75	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.3 - 0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.8 - 1	%	ASTM D 955
Density	1.63	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.98	%	ISO 62

Source GMD, last updated:2009/06/19

Processing

Parameter	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

Source GMD, last updated:2009/06/19

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) 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.

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