

## LNP\* Thermotuf\* Compound R1000I

Americas: COMMERCIAL

Also known as: R-1000 HI 020  
Product Reorder Name: R1000I

High Impact Nylon 66 compound containing Impact Modifier.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, break	45	MPa	ISO 527
Tensile Strain, break	70	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress	50	MPa	ISO 178
Flexural Modulus	1400	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	98	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	55	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	65	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Mold Shrinkage, flow, 24 hrs	1.1 - 1.5	%	ISO 294
Density	1.09	g/cm <sup>3</sup>	ISO 1183

Source GMD, last updated:09/30/2004

### 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	260 - 270	°C
Middle - Zone 2 Temperature	255 - 265	°C
Rear - Zone 1 Temperature	250 - 260	°C
Mold Temperature	60 - 100	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

Source GMD, last updated:09/30/2004

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.

**Disclaimer :** THE MATERIALS AND PRODUCTS OF THE BUSINESSES MAKING UP THE SABIC INNOVATIVE PLASTICS COMPANY, ITS SUBSIDIARIES AND AFFILIATES ("SABIC IP"), ARE SOLD SUBJECT TO SABIC IP' S STANDARD CONDITIONS OF SALE, WHICH ARE INCLUDED IN THE APPLICABLE DISTRIBUTOR OR OTHER SALES AGREEMENT, PRINTED ON THE BACK OF ORDER ACKNOWLEDGMENTS AND INVOICES, AND AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION, RECOMMENDATIONS, OR ADVICE CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SABIC IP MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (I) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (II) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING SABIC IP MATERIALS, PRODUCTS, RECOMMENDATIONS OR ADVICE. EXCEPT AS PROVIDED IN SABIC IP' S STANDARD CONDITIONS OF SALE, SABIC IP AND ITS REPRESENTATIVES SHALL IN NO EVENT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS MATERIALS OR PRODUCTS DESCRIBED HEREIN. Each user bears full responsibility for making its own determination as to the suitability of SABIC IP' s materials, products, recommendations, or advice for its own particular use. Each user must identify and perform all tests and analyses necessary to assure that its finished parts incorporating SABIC IP materials or products will be safe and suitable for use under end-use conditions. Nothing in this or any other document, nor any oral recommendation or advice, shall be deemed to alter, vary, supersede, or waive any provision of SABIC IP' s Standard Conditions of Sale or this Disclaimer, unless any such modification is specifically agreed to in a writing signed by SABIC IP. No statement contained herein concerning a possible or suggested use of any material, product or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of SABIC Innovative Plastics Company or any of its subsidiaries or affiliates covering such use or design, or as a recommendation for the use of such material, product or design in the infringement of any patent or other intellectual property right

\* LNP is a trademark of the SABIC Innovative Plastics Company

\* Thermotuf is a trademark of the SABIC Innovative Plastics Company

© 1997-2008 SABIC Innovative Plastics Company.All rights reserved