

**Product Texts**

LNP THERMOTUF R1000I compound is based on Nylon 6/6 resin containing Impact Modifier.

**Processing/Physical Characteristics**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	1.3	%	ISO 294-4, 2577

**Mechanical properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	2200	MPa	ISO 527
Stress at break	45	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus	1400	MPa	ISO 178
Flexural strength	50	MPa	ISO 178
Izod impact strength, +23°C, 4mm	98	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	55	kJ/m <sup>2</sup>	ISO 180/1A

**Thermal properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	65	°C	ISO 75-1/-2

**Other properties**

	Value	Unit	Test Standard
Density	1090	kg/m <sup>3</sup>	ISO 1183

**Processing Recommendation Injection Molding**

	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.25	%	-
Melt temperature	265 - 275	°C	-
Mold temperature	60 - 100	°C	-
Zone 1	250 - 260	°C	-
Zone 2	255 - 265	°C	-
Zone 3	260 - 270	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific