

## LNP\* Lubricomp\* Compound PFP36

Americas: COMMERCIAL

Also known as: PM-3603 HI 012  
Product Reorder Name: PFP36

High Impact Nylon 6 compound containing Impact Modifier, Mineral.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, break	55	MPa	ISO 527
Tensile Strain, break	6 - 8	%	ISO 527
Tensile Modulus, 1 mm/min	3200	MPa	ISO 527
Flexural Stress	80	MPa	ISO 178
Flexural Modulus	3100	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched 80*10*4 +23°C	100	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	58	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Mold Shrinkage, flow, 24 hrs	1.2 - 1.4	%	ISO 294
Density	1.22	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	255 - 265	°C
Front - Zone 3 Temperature	250 - 260	°C
Middle - Zone 2 Temperature	250 - 260	°C
Rear - Zone 1 Temperature	245 - 255	°C
Mold Temperature	55 - 95	°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.

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