

TECHNICAL DATASHEET

TRILFT® LF4000G30

Polyamide + Long Glass Fiber

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.35
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,600
Flexural Strength at yield	kg _f /cm ²	D790	2,200
Flexural Modulus	kg _f /cm ²	D790	82,000
Izod Impact Strength, notched, 23℃ (1/8")	kg _f ·cm/cm	D256	15
THERMAL			
HDT, 4.6 kgf/cm ²	℃		210
ELECTRICAL			
OTHERS			
Mold Shrinkage	%		0.1~0.15

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRILFT® LF4000G30 GRADE

Polyamide + Long Glass Fiber

- General processing conditions for TRILFTLF4000G30 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	110
Drying Time	hr	4-6
Moisture Content, Max	%	0.02
Melt Temperature	℃	250~280
Nozzle Temperature	℃	250~280
Front Temperature	℃	250~280
Middle Temperature	℃	240~260
Rear Temperature	℃	230~250
Mold Temperature	℃	60~80
Back Pressure	MPa	<70
Screw Speed	rpm	<60
Injection Pressure	MPa	<70
Injection Speed	%	<60
Hold Pressure	MPa	<50
Injection Cushion	mm	3~6

Global Network

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