TECHNICAL DATASHEET

TRILFT® LF4000G50

Polyamide + Long Glass Fiber

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
Specific Gravity	-	D792	1.57
MECHANICAL			
Tensile Strength at yield	kg_f/cm^2	D638	2,500
Flexural Strength at yield	kg_f/cm^2	D790	3,500
Flexural Modulus	kg_f/cm^2	D790	135,000
Izod Impact Strength, notched, 23℃ (1/8")	$kg_f \cdot cm/cm$	D256	24
THERMAL			
HDT, 4.6 kgf/㎠	℃		215
ELECTRICAL			
OTHERS			
Mold Shrinkage (3mm thickness)	%	D955	0.3~0.5

※ 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® LF4000G50 GRADE

Polyamide + Long Glass Fiber

- General processing conditions for TRILFTLF4000G50 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

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