LNP™ THERMOCOMP™ COMPOUND RC004SXS

RC-1004 HS
REGION EUROPE

DESCRIPTION

LNP THERMOCOMP RC004SXS is a compound based on Nylon 66 containing 20% Carbon Fiber. Added feature of this grade includes: Heat Stabilized, Electrically Conductive.

TYPICAL PROPERTY VALUES

Revision 20181227

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	200	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Flexural Stress, break, 2 mm/min	269	MPa	ISO 178
Flexural Modulus, 2 mm/min	10500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	35	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	1.7E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	249	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.1 – 0.3	%	SABIC method
Density	1.23	g/cm³	ISO 1183
ELECTRICAL			
Surface Resistivity	1.E+02 – 1.E+04	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	280 – 305	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	280 – 295	°C	
Rear - Zone 1 Temperature	265 – 275	°C	
Mold Temperature	95 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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