LNP™ THERMOCOMP™ COMPOUND RF004XXH

RF-1004 HC

DESCRIPTION

LNP THERMOCOMP* RF004XXH is a compound based on Nylon 66 resin containing 20% Glass Fiber. Added feature of this grade is: Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	149	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.8	%	ASTM D 638
Tensile Modulus, 5 mm/min	7980	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	233	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	7130	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	148	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.8	%	ISO 527
Tensile Modulus, 1 mm/min	7640	MPa	ISO 527
Flexural Stress	217	MPa	ISO 178
Flexural Modulus, 2 mm/min	6400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	593	J/m	ASTM D 4812
Izod Impact, notched, 23°C	74	J/m	ASTM D 256
Multiaxial Impact	2	J	ISO 6603
Instrumented Impact Total Energy, 23°C	7	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	39	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	260	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	255	°C	ASTM D 648
CTE, -30°C to 30°C, flow	4.8E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	8.4E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	258	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	241	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Density	1.29	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.78	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.4 – 0.6	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.44	%	ISO 62
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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