LNP™ THERMOCOMP™ COMPOUND RF006EXZ

RF-1006 EM

DESCRIPTION

LNP THERMOCOMP* RF006EXZ is a compound based on Nylon 66 resin containing 30% Glass Fiber. Added features of this material include: Easy Molding.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	140	MPa	ASTM D 638
Tensile Strain, break	2.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	9850	MPa	ASTM D 638
Flexural Stress	206	MPa	ASTM D 790
Flexural Modulus	7440	MPa	ASTM D 790
Tensile Stress, break	140	MPa	ISO 527
Tensile Strain, break	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	9400	MPa	ISO 527
Flexural Stress	217	MPa	ISO 178
Flexural Modulus	8900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	731	J/m	ASTM D 4812
Izod Impact, notched, 23°C	80	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	8	J	ASTM D 3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	46	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	252	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	230	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.97E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.41E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.69E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.46E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	222	°C	ISO 75/Af
PHYSICAL			
Density	1.4	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.87	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.9 – 1.1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.9 – 1.1	%	ISO 294
Density	1.39	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	1.07	%	ISO 62

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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