LNP™ THERMOCOMP™ COMPOUND RF008H

RF-1008 USS

DESCRIPTION

LNP* THERMOCOMP* RF008H is a compound based on Nylon 66 containing 40% Glass Fiber. Added feature of this grade is: Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	184	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	13300	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	275	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	10410	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	188	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.7	%	ISO 527
Tensile Modulus, 1 mm/min	12200	MPa	ISO 527
Flexural Stress	287	MPa	ISO 178
Flexural Modulus, 2 mm/min	12100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1137	J/m	ASTM D 4812
Izod Impact, notched, 23°C	117	J/m	ASTM D 256
Multiaxial Impact	3	J	ISO 6603
Instrumented Impact Total Energy, 23°C	10	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	74	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	13	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	252	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.52E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.76E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.68E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.92E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	>240	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.5	-	ASTM D 792
Density	1.478	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.6	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.1 – 0.3	%	ISO 294
Density	1.47	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.97	%	ISO 62
INJECTION MOLDING			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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