LNP™ THERMOCOMP™ COMPOUND RFB71S

RF-1008 HS MG

DESCRIPTION

LNP THERMOCOMP RFB71S is a compound based on Nylon 66 resin containing Glass Fiber, Glass Bead. Added features of this material include: Heat Stabilized.

TYPICAL PROPERTY VALUES

Revision 20200109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	99	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3.3	%	ISO 527
Tensile Modulus, 1 mm/min	5800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	155	MPa	ISO 178
Flexural Stress, break, 2 mm/min	90	MPa	ISO 178
Flexural Modulus, 2 mm/min	5000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	5.2E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	7.3E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	243	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Af
Relative Temp Index, Elec (1)	65	°C	UL 746B
Relative Temp Index, Mech w/impact (1)	65	°C	UL 746B
Relative Temp Index, Mech w/o impact (1)	65	°C	UL 746B
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	0.7 – 0.9	%	SABIC method
Density	1.45	g/cm³	ISO 1183
FLAME CHARACTERISTICS (1)			
UL Yellow Card Link	E45329-101282594	-	-
UL Recognized, 94HB Flame Class Rating	1.5	mm	UL 94
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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Screw Speed	30 – 60	rpm	

(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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