LNP™ THERMOCOMP™ COMPOUND RZ006

RF-1006 M

DESCRIPTION

LNP THERMOCOMP* RZ006 is a compound based on Nylon 66 resin containing 30% Milled Glass.

TYPICAL PROPERTY VALUES

Revision 20191213

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	68	MPa	ASTM D 638
Tensile Strain, break	4.3	%	ASTM D 638
Flexural Stress	119	MPa	ASTM D 790
Flexural Modulus	4300	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	320	J/m	ASTM D 4812
Izod Impact, notched, 23°C	32	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	115	°C	ASTM D 648
PHYSICAL			
Density	1.39	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	1.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.5	%	ASTM D 955
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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