

LNP™ THERMOCOMP™ RFB53XXZ

compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RFB53XXZ is a compound based on Nylon 66 resin containing 15% Glass Fiber, 25% Glass Bead.

Also known as: LNP* THERMOCOMP* Compound RF-1008 MG

Product reorder name: RFB53XXZ

General Information			
Filler / Reinforcement	Glass Bead,25% Filler by Weight		
	Glass Fiber,15% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.46	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.40 to 0.70	%	
Across Flow : 24 hr	0.90 to 2.0	%	
Water Absorption			
24 hr, 50% RH	0.63	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.95	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8450	MPa	ASTM D638
--	8110	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	124	MPa	ASTM D638
Yield	125	MPa	ISO 527-2/5
Break ³	115	MPa	ASTM D638
Break	124	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.6	%	ASTM D638
Yield	2.6	%	ISO 527-2/5
Break ⁵	2.7	%	ASTM D638
Break	2.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	7320	MPa	ASTM D790
-- ⁷	7050	MPa	ISO 178

Flexural Stress			
--	183	MPa	ISO 178
Yield, 50.0 mm Span ⁸	186	MPa	ASTM D790
Break, 50.0 mm Span ⁹	186	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	37	J/m	ASTM D256
23°C ¹⁰	4.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	500	J/m	ASTM D4812
23°C ¹¹	33	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	7.70	J	ASTM D3763
--	2.10	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	256	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	253	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	241	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	234	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	4.0E-5	cm/cm/°C	
Transverse : -30 to 30°C	8.4E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	266 to 277	°C	
Middle Temperature	282 to 293	°C	
Front Temperature	293 to 304	°C	
Processing (Melt) Temp	282 to 304	°C	
Mold Temperature	93.3 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		

8.	1.3 mm/min
9.	1.3 mm/min
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	80*10*4 mm

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