

LNP™ THERMOCOMP™ RF004S compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RF004S is a Nylon 6/6 containing Glass Fiber. Characteristics are Heat Stabilized.

Also known as: LNP* THERMOCOMP* Compound RF-1004 HS BK8-115

Product Reorder name: RF004S

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.50 to 0.80	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	1.0	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7930	MPa	ASTM D638
--	7190	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	121	MPa	ASTM D638
Yield	121	MPa	ISO 527-2/5
Break ³	121	MPa	ASTM D638
Break	121	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.2	%	ASTM D638
Yield	2.0	%	ISO 527-2/5
Break ⁵	2.2	%	ASTM D638
Break	2.0	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	5350	MPa	ASTM D790
-- ⁷	5870	MPa	ISO 178
Flexural Stress			
--	186	MPa	ISO 178
Yield, 50.0 mm Span ⁸	187	MPa	ASTM D790

Break, 50.0 mm Span ⁹	188	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	50	J/m	ASTM D256
23°C ¹⁰	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	520	J/m	ASTM D4812
23°C ¹¹	31	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	7.50	J	ASTM D3763
--	1.40	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	255	°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	236	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	226	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.0E-6	cm/cm/°C	
Transverse : -30 to 30°C	8.0E-6	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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