

LNP™ THERMOCOMP™ RFB66 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RFB66 is a compound based on Nylon 66 resin containing 30% Glass Fiber, 30% Glass Bead.

Also known as: LNP* THERMOCOMP* Compound RF-100-12 MG

Product reorder name: RFB66

General Information			
Filler / Reinforcement	Glass Bead,30% Filler by Weight		
	Glass Fiber,30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.70	g/cm ³	
--	1.69	g/cm ³	
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	0.34	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.51	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	15000	MPa	ASTM D638
--	13400	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	138	MPa	ASTM D638
Yield	128	MPa	ISO 527-2/5
Break	152	MPa	ASTM D638
Break ³	138	MPa	ASTM D638
Break	122	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.8	%	ASTM D638
Yield	1.7	%	ISO 527-2/5
Break	1.7	%	ASTM D638, ISO 527-2/5
Break ⁵	1.8	%	ASTM D638
Flexural Modulus			
--	13800	MPa	ASTM D790
50.0 mm Span ⁶	13000	MPa	ASTM D790

-- ⁷	12600	MPa	ISO 178
Flexural Strength			
--	248	MPa	ASTM D790
--	209	MPa	ISO 178
Yield, 50.0 mm Span ⁸	222	MPa	ASTM D790
Break, 50.0 mm Span ⁹	221	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	64	J/m	ASTM D256
23°C ¹⁰	6.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	530	J/m	ASTM D4812
23°C ¹¹	37	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.5	J	ASTM D3763
--	4.20	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	257	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	249	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	244	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	232	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.5E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.1E-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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