

LNP™ THERMOCOMP™ RF006H compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* RF006H is a compound based on Nylon 66 resin containing 30% Glass Fiber. Added feature of this grade is: Healthcare.

Also known as: LNP* THERMOCOMP* Compound RF-1006

Product reorder name: RF006H

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
	1.40		
--	1.41	g/cm ³	ASTM D792
--	1.40	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 24 hr	0.30 to 0.50	%	
Across Flow : 24 hr	1.4 to 1.6	%	
Water Absorption			
24 hr, 50% RH	0.69	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8980	MPa	ISO 527-2/1
Tensile Strength			
Break ¹	165	MPa	ASTM D638
Break	154	MPa	ISO 527-2/5
Tensile Elongation			
Break ²	2.4	%	ASTM D638
Break	2.4	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ³	9440	MPa	ASTM D790
-- ⁴	9220	MPa	ISO 178
Flexural Strength ⁵ (Break, 50.0 mm Span)	235	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.71		
vs. Itself - Static	0.57		

Wear Factor - Washer	75.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	59	J/m	ASTM D256
23°C ⁶	7.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	650	J/m	ASTM D4812
23°C ⁷	52	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	6.50	J	ASTM D3763
--	2.57	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	265	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	255	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁸	243	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	3.0E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.3E-5	cm/cm/°C	
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm, Testing by SABIC)	HB		UL 94
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.	Type I, 5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	1.3 mm/min		
4.	2.0 mm/min		
5.	1.3 mm/min		
6.	80*10*4		
7.	80*10*4		
8.	80*10*4 mm		

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