

LNP™ THERMOCOMP™ RF006EXZ compound

Polyamide 66
SABIC Innovative Plastics

Message:

LNP THERMOCOMP* RF006EXZ is a compound based on Nylon 66 resin containing 30% Glass Fiber. Added features of this material include: Easy Molding.
Also known as: LNP* THERMOCOMP* Compound RF-1006 EM
Product reorder name: RF006EXZ

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Good Moldability		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.40	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 24 hr	0.20 to 0.40	%	
Across Flow : 24 hr	0.90 to 1.1	%	
Water Absorption			
24 hr, 50% RH	0.87	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.1	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	9860	MPa	ASTM D638
--	9400	MPa	ISO 527-2/1
Tensile Strength			
Break	141	MPa	ASTM D638
Break	140	MPa	ISO 527-2
Tensile Elongation			
Break	2.3	%	ASTM D638
Break	2.6	%	ISO 527-2
Flexural Modulus			
--	7450	MPa	ASTM D790
--	8900	MPa	ISO 178
Flexural Strength			
--	207	MPa	ASTM D790
--	218	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	80	J/m	ASTM D256
23°C ²	8.6	kJ/m ²	ISO 180/1A

Unnotched Izod Impact			
23°C	730	J/m	ASTM D4812
23°C ³	47	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	8.10	J	ASTM D3763
--	2.50	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	253	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	231	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	222	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	3.0E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	2.7E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	7.4E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	7.5E-5	cm/cm/°C	ISO 11359-2
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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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