

LNP™ THERMOCOMP™ RF007SXR

compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RF007SXR is a compound based on Nylon 66 resin containing 35% Glass Fiber. Added features of this material includes: Heat Stabilized, Hydrolysis Resistant.

Also known as: LNP* THERMOCOMP* Compound RF007SXR

Product reorder name: RF007SXR

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 35% filler by weight		
Additive	heat stabilizer		
Features	Hydrolysis resistance		
	Thermal Stability		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	3.78	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.30 - 0.50	%	ASTM D955
Transverse flow: 24 hours	1.0 - 3.0	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.45	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.51	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	11900	MPa	ASTM D638
--	11700	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	195	MPa	ASTM D638
Fracture ³	175	MPa	ASTM D638
Fracture	193	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ⁴	2.5	%	ASTM D638
Fracture	2.5	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁵	10600	MPa	ASTM D790
-- ⁶	9840	MPa	ISO 178
Flexural Stress			

--	268	MPa	ISO 178
Yield, 50.0mm span ⁷	285	MPa	ASTM D790
Fracture, 50.0mm span ⁸	284	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C ⁹	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1000	J/m	ASTM D4812
23°C ¹⁰	61	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	7.56	J	ASTM D3763
--	3.04	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	261	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ¹¹	261	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	255	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹²	252	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM D696
Flow: -30 to 30°C	3.8E-5	cm/cm/°C	ASTM D696
Lateral: -30 to 30°C	6.3E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 - 0.25	%	
Rear Temperature	266 - 277	°C	
Middle Temperature	282 - 293	°C	
Front Temperature	293 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	93.3 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	1.3 mm/min		
6.	2.0 mm/min		
7.	1.3 mm/min		
8.	1.3 mm/min		

9.	80*10*4
10.	80*10*4
11.	80*10*4 mm
12.	80*10*4 mm

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