

LNP™ THERMOCOMP™ RF008 compound

Polyamide 66

SABIC Innovative Plastics Asia Pacific

Message:

LNP THERMOCOMP RF008 is a compound based on PA66 resin containing glass fiber. It is used in many applications requiring high strength over weight performance. Also known as THERMOCOMP RF-1008

Also known as: LNP* THERMOCOMP* Compound RF-1008

Product reorder name: RF008

General Information			
Filler / Reinforcement	Glass Fiber		
Features	High Strength		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.48	g/cm ³	ASTM D792
--	1.47	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30	%	
Across Flow : 24 hr	1.3	%	
Water Absorption (24 hr, 50% RH)	0.60	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	13300	MPa	ASTM D638
--	12200	MPa	ISO 527-2/1
Tensile Strength			
Break ²	185	MPa	ASTM D638
Break	189	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.5	%	ASTM D638
Break	2.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	10400	MPa	ASTM D790
-- ⁵	12100	MPa	ISO 178
Flexural Strength ⁶ (Break, 50.0 mm Span)	275	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	120	J/m	ASTM D256
23°C ⁷	13	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1100	J/m	ASTM D4812

23°C ⁸	74	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	253	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	240	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	2.7E-5	cm/cm/°C	ASTM E831
Flow : 23 to 60°C	2.7E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	5.9E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 60°C	5.9E-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.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		

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