

LNP™ THERMOCOMP™ RF005 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RF005 is a compound based on Nylon 66 resin containing 25% Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound RF-1005

Product reorder name: RF005

General Information			
Filler / Reinforcement	Glass Fiber,25% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30	%	
Across Flow : 24 hr	1.4	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	9100	MPa	ASTM D638
--	8300	MPa	ISO 527-2/1
Tensile Strength			
Break	132	MPa	ASTM D638
Break	140	MPa	ISO 527-2
Tensile Elongation			
Break	1.9	%	ASTM D638
Break	2.0	%	ISO 527-2
Flexural Modulus			
--	7240	MPa	ASTM D790
--	8300	MPa	ISO 178
Flexural Strength			
--	193	MPa	ASTM D790
--	205	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	69	J/m	ASTM D256
23°C ²	6.6	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	480	J/m	ASTM D4812
23°C ³	33	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	7.00	J	ASTM D3763

--	2.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	259	°C	ASTM D648
1.8 MPa, Unannealed, 3.20 mm	246	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	224	°C	ISO 75-2/Af
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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