

LNP™ THERMOCOMP™ RF004XXH

compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* RF004XXH is a compound based on Nylon 66 resin containing 20% Glass Fiber. Added feature of this grade is: Healthcare.

Also known as: LNP* THERMOCOMP* Compound RF-1004 HC

Product reorder name: RF004XXH

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.29	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.40 to 0.60	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.78	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.44	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7980	MPa	ASTM D638
--	7640	MPa	ISO 527-2/1
Tensile Strength			
Break ²	149	MPa	ASTM D638
Break	148	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.8	%	ASTM D638
Break	2.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	7130	MPa	ASTM D790
-- ⁵	6410	MPa	ISO 178
Flexural Stress			
--	217	MPa	ISO 178
Break, 50.0 mm Span ⁶	233	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			

23°C	74	J/m	ASTM D256
23°C ⁷	6.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	590	J/m	ASTM D4812
23°C ⁸	39	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	7.02	J	ASTM D3763
--	2.20	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	260	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	258	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	255	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	241	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	4.8E-5	cm/cm/°C	
Transverse : -30 to 30°C	8.4E-5	cm/cm/°C	
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.	5.0 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		
10.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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