

LNP™ THERMOCOMP™ RF004H compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RF004H is a compound based on Nylon 66 containing 20% Glass Fiber. Added feature of this grade is: Healthcare.

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

Product reorder name: RF004H

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			ASTM D792
--	1.30	g/cm ³	
--	1.29	g/cm ³	
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)	0.89	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7170	MPa	ASTM D638
--	7300	MPa	ISO 527-2/1
Tensile Strength			
Break ²	156	MPa	ASTM D638
Break	159	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	3.6	%	ASTM D638
Break	3.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	5860	MPa	ASTM D790
-- ⁵	7000	MPa	ISO 178
Flexural Stress			
--	242	MPa	ISO 178
Break, 50.0 mm Span ⁶	230	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C ⁷	8.6	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			

23°C	830	J/m	ASTM D4812
23°C ⁸	56	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	11.4	J	ASTM D3763
--	2.49	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
1.8 MPa, Unannealed, 3.20 mm	247	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁹	221	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	3.8E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	3.9E-5	cm/cm/°C	ISO 11359-2
Flow : 23 to 60°C	7.9E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	7.9E-5	cm/cm/°C	ASTM E831
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		

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