

LNP* Thermocomp* Compound RF006 Americas: COMMERCIAL

Also known as: RF-1006

Product Reorder Name: RF006

LNP* Thermocomp* RF006 is a compound based on Nylon 66 resin containing Glass Fiber.

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	167	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	11420	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	243	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	242	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	9700	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	160	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.4	%	ISO 527
Tensile Modulus, 1 mm/min	10570	MPa	ISO 527
Flexural Stress	233	MPa	ISO 178
Flexural Modulus, 2 mm/min	9400	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, notched, 23°C	67	J/m	ASTM D 256
Multiaxial Impact	2	J	ISO 6603
Instrumented Impact Total Energy, 23°C	6	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	44	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 1.82 MPa, 3.2mm, unannealed	246	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.71E+01	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	9.81E+01	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	255	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	236	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard

Specific Gravity	1.41	-	ASTM D 792
Density	1.4	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.64	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.3 - 0.6	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.9 - 2	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.94	%	ISO 62

Source GMD, last updated:2010/03/25

Processing

Parameter		
Injection Molding	Value	Unit
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	280 - 305	°C
Front - Zone 3 Temperature	295 - 305	°C
Middle - Zone 2 Temperature	280 - 295	°C
Rear - Zone 1 Temperature	265 - 275	°C
Mold Temperature	95 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm

Source GMD, last updated:2010/03/25

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

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