

## LNP\* Thermocomp\* Compound RF006H

Americas: COMMERCIAL

Also known as: RF-1006

Product Reorder Name: RF006H

LNP THERMOCOMP\* RF006H is a compound based on Nylon 66 resin containing Glass Fiber.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, break	165	MPa	ASTM D 638
Tensile Strain, break	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	10680	MPa	ASTM D 638
Flexural Stress	235	MPa	ASTM D 790
Flexural Modulus	9440	MPa	ASTM D 790
Tensile Stress, break	154	MPa	ISO 527
Tensile Strain, break	2.4	%	ISO 527
Tensile Modulus, 1 mm/min	8980	MPa	ISO 527
Flexural Stress	234	MPa	ISO 178
Flexural Modulus	9220	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	646	J/m	ASTM D 4812
Izod Impact, notched, 23°C	58	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	6	J	ASTM D 3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	52	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	265	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	255	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.04E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.32E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.04E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.32E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	243	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.4	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.69	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.3 - 0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.4 - 1.6	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.3 - 0.5	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.4 - 1.6	%	ISO 294
Wear Factor Washer	75	10 <sup>-10</sup> in <sup>4</sup> -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.71	-	ASTM D 3702 Modified
Static COF	0.57	-	ASTM D 3702 Modified
Density	1.39	g/cm <sup>3</sup>	ISO 1183
Moisture Absorption (23°C / 50% RH)	1.2	%	ISO 62

FLAME CHARACTERISTICS	Value	Unit	Standard
UL Compliant, 94HB Flame Class Rating (3)(4)	1.5	mm	UL 94 by GE

Source GMD, last updated:2010/03/17

## Processing

Parameter	Value	Unit
Injection Molding		
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:2010/03/17

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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