

LNP* Thermocomp* Compound RX10405H

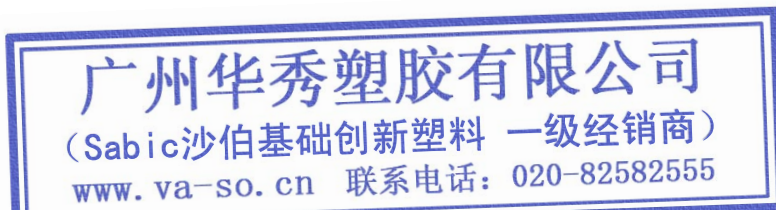
Americas: COMMERCIAL

Also known as: LNP* Thermocomp* Compound RX10405H

Product reorder name: RX10405H

LNP* Thermocomp* RX10405H is a compound based on Nylon 6/6 containing Glass Fiber. Characteristics of this grade are: Healthcare.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1870	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	135600	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	2800	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	106100	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	188	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.7	%	ISO 527
Tensile Modulus, 1 mm/min	12200	MPa	ISO 527
Flexural Stress	287	MPa	ISO 178
Flexural Modulus, 2 mm/min	12100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	115	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	11	cm-kgf/cm	ASTM D 256
Multiaxial Impact	30	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	101	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	74	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	13	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	252	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.52E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.76E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.68E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.92E-05	1/°C	ISO 11359-2



(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±176.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.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	>240	°C	ISO 75/Af
PHYSICAL			
Density	1.478	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.6	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.2 - 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1 - 3	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.3	%	ISO 294
Density	1.47	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.97	%	ISO 62



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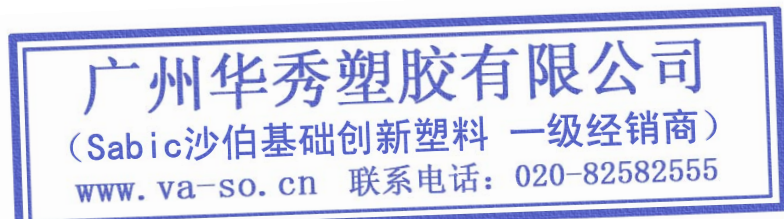
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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	280 - 305	°C
Front - Zone 3 Temperature	295 - 305	°C
Middle - Zone 2 Temperature	280 - 295	°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



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