

LNP™ STAT-KON™ RFD04 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP STAT-KON* RFD04 is a compound based on Nylon 66 resin containing 20% Glass Fiber. Added features of this material include: Electrically Conductive.

Also known as: LNP* STAT-KON* Compound RF-20

Product reorder name: RFD04

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Features	Electrically Conductive		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.40	g/cm ³	ASTM D792
--	1.39	g/cm ³	ISO 1183, ASTM D792
Molding Shrinkage			
Flow : 24 hr	0.50 to 0.70	%	ASTM D955
Across Flow : 24 hr	1.0 to 3.0	%	ASTM D955
Across Flow : 24 hr	1.4	%	ISO 294-4
Flow : 24 hr	0.61	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.50	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.75	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	9200	MPa	ASTM D638
--	8780	MPa	ISO 527-2/1
Tensile Strength			
Break ²	124	MPa	ASTM D638
Break	117	MPa	ISO 527-2
Break	119	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.7	%	ASTM D638
Break	1.4	%	ISO 527-2
Break	1.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	8540	MPa	ASTM D790
--	8600	MPa	ISO 178
-- ⁵	8180	MPa	ISO 178

Flexural Stress			
--	185	MPa	ISO 178
Break, 50.0 mm Span ⁶	190	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	36	J/m	ASTM D256
23°C ⁷	3.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	300	J/m	ASTM D4812
23°C ⁸	20	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	3.60	J	ASTM D3763
--	1.46	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	259	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	257	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	248	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	242	°C	ISO 75-2/Af
CLTE			
Flow : -30 to 30°C	3.4E-5	cm/cm/°C	ASTM D696
Flow : -40 to 40°C	3.2E-5	cm/cm/°C	ISO 11359-2
Transverse : -30 to 30°C	6.1E-5	cm/cm/°C	ASTM D696
Transverse : -40 to 40°C	6.5E-5	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+3 to 1.0E+7	ohms	ASTM D257
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.	50 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*3
9.	80*10*4 mm
10.	80*10*4 mm

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