

LNP™ THERMOCOMP™ RFZ349XC

compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* RFZ349XC is a compound based on Nylon 66 resin containing 20% Glass Fiber, 15% Milled Glass. Added features of this material include: Flame Retardant.

Also known as: LNP* THERMOCOMP* Compound RF-1007 FR MG LEX

Product reorder name: RFZ349XC

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
	Milled Glass Fiber,15% Filler by Weight		
Features	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.66	g/cm ³	ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.40	%	ASTM D955
Across Flow : 24 hr	1.2	%	ASTM D955, ISO 294-4
Flow : 24 hr	0.39	%	ISO 294-4
Water Absorption			
24 hr, 50% RH	0.20	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.43	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	11000	MPa	ASTM D638
--	11400	MPa	ISO 527-2/1
Tensile Strength			
Break	125	MPa	ASTM D638
Break	85.0	MPa	ISO 527-2
Tensile Elongation			
Break	2.3	%	ASTM D638
Break	3.2	%	ISO 527-2
Flexural Modulus			
--	7170	MPa	ASTM D790
--	9000	MPa	ISO 178
Flexural Strength			
--	179	MPa	ASTM D790

--	197	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	64	J/m	ASTM D256
23°C ²	7.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	590	J/m	ASTM D4812
23°C ³	39	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	7.00	J	ASTM D3763
--	2.30	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	237	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁴	235	°C	ISO 75-2/Af
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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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