

LNP™ THERMOCOMP™ RX99732C compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RX99732C is a compound based on Nylon 66 resin containing Proprietary Filler(s). Added feature of this material is: Clean Compounding System.

Also known as: LNP* THERMOCOMP* Compound PDX-R-99732

Product reorder name: RX99732C

General Information			
Filler / Reinforcement	Proprietary		
Features	Low (to None) Ion Content		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.10 to 0.30	%	
Across Flow : 24 hr	0.90 to 2.0	%	
Water Absorption			
24 hr, 50% RH	0.59	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.81	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	15200	MPa	ASTM D638
--	14000	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	186	MPa	ASTM D638
Yield	186	MPa	ISO 527-2/5
Break ³	186	MPa	ASTM D638
Break	186	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.8	%	ASTM D638
Yield	2.7	%	ISO 527-2/5
Break ⁵	3.0	%	ASTM D638
Break	2.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	10200	MPa	ASTM D790
-- ⁷	10800	MPa	ISO 178
Flexural Strength ⁸			ASTM D790
Yield, 50.0 mm Span	253	MPa	
Break, 50.0 mm Span	250	MPa	

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	150	J/m	ASTM D256
23°C ⁹	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1300	J/m	ASTM D4812
23°C ¹⁰	75	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	17.5	J	ASTM D3763
--	3.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	252	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	253	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	234	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	234	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	2.3E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.1E-5	cm/cm/°C	
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.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4		
10.	80*10*4		
11.	80*10*4 mm		

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