

LNP™ THERMOCOMP™ RF0069XZ compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP* RF0069XZ is a compound based on Nylon 66 resin containing 30% Glass Fiber. Added features of this material include: Flame Retardant.

Also known as: LNP* THERMOCOMP* Compound RF-1006 FR

Product reorder name: RF0069XZ

General Information			
UL YellowCard	E121562-101281619		
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Flame Retardant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.69	g/cm ³	ASTM D792
--	1.68	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.20 to 0.50	%	
Across Flow : 24 hr	1.0 to 4.0	%	
Water Absorption			
24 hr, 50% RH	0.36	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.54	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	13400	MPa	ASTM D638
--	13100	MPa	ISO 527-2/1
Tensile Strength			
Break ²	160	MPa	ASTM D638
Break	155	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.1	%	ASTM D638
Break	1.9	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	11500	MPa	ASTM D790
-- ⁵	12000	MPa	ISO 178
Flexural Strength ⁶ (Break, 50.0 mm Span)	237	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	73	J/m	ASTM D256

23°C ⁷	8.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	730	J/m	ASTM D4812
23°C ⁸	45	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	8.20	J	ASTM D3763
--	2.70	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	254	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	255	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	241	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	240	°C	ISO 75-2/Af
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm)	V-0		UL 94
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*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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