

LNP™ THERMOCOMP™ RF00AH compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP THERMOCOMP RF00AH is a compound based on Nylon 66 resin containing Glass Fiber.

Also known as: LNP* THERMOCOMP* Compound RF-100-10

Product reorder name: RF00AH

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.60	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.30 - 0.50	%	ASTM D955
Transverse flow: 24 hours	1.1 - 1.3	%	ASTM D955
Vertical flow direction: 24 hours	1.2	%	ISO 294-4
Flow direction: 24 hours	0.37	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.40	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	17200	MPa	ASTM D638
--	17800	MPa	ISO 527-2/1
Tensile Strength			
Fracture	166	MPa	ASTM D638
Fracture	182	MPa	ISO 527-2
Tensile Elongation			
Fracture	7.8	%	ASTM D638
Fracture	8.1	%	ISO 527-2
Flexural Modulus			
--	14500	MPa	ASTM D790
--	14900	MPa	ISO 178
Flexural Strength			
--	262	MPa	ASTM D790
--	265	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	96	J/m	ASTM D256
23°C ²	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	940	J/m	ASTM D4812

23°C ³	60	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	253	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	244	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁴	243	°C	ISO 75-2/Af
Linear thermal expansion coefficient			
Flow: -40 to 40°C	5.2E-5	cm/cm/°C	ASTM E831
Flow: -40 to 40°C	5.1E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	2.2E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 - 0.25	%	
Rear Temperature	266 - 277	°C	
Middle Temperature	282 - 293	°C	
Front Temperature	293 - 304	°C	
Processing (Melt) Temp	282 - 304	°C	
Mold Temperature	93.3 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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