

LNP™ THERMOCOMP™ RF0069SZ compound

Polyamide 66

SABIC Innovative Plastics Asia Pacific

Message:

LNP THERMOCOMP RF0069SZ is a compound based on Nylon 66 resin containing 30% Glass Fiber. Added features of th is grade include: Flame Retardant, Heat Stabilized.

Also known as: LNP* THERMOCOMP* Compound RF-1006 FR-1 HS

Product reorder name: RF0069SZ

General Information			
UL YellowCard	E121562-101281595	E121562-101281598	E121562-101282587
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	heat stabilizer		
Features	Thermal Stability		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.67	g/cm ³	ASTM D792
--	1.66	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.30 - 0.50	%	ASTM D955
Transverse flow: 24 hours	1.0 - 3.0	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.40	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.79	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	12800	MPa	ASTM D638
--	12800	MPa	ISO 527-2/1
Tensile Strength			
Fracture ²	157	MPa	ASTM D638
Fracture	157	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ³	2.0	%	ASTM D638
Fracture	1.8	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁴	11400	MPa	ASTM D790
-- ⁵	11000	MPa	ISO 178
Flexural Stress			

--	217	MPa	ISO 178
Fracture, 50.0mm span ⁶	221	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	67	J/m	ASTM D256
23°C ⁷	6.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	640	J/m	ASTM D4812
23°C ⁸	37	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	6.80	J	ASTM D3763
--	1.90	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	246	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁹	246	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	231	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁰	227	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM D696
Flow: -30 to 30°C	2.7E-5	cm/cm/°C	ASTM D696
Lateral: -30 to 30°C	5.3E-5	cm/cm/°C	ASTM D696
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	277 - 288	°C	
Mold Temperature	82.2 - 93.3	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 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		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

