

LNP* Thermocomp* Compound RX06324

Asia Pacific: COMMERCIAL

This material is Mineral filled Nylon grade with high dielectric constant

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	0	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	730	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	0	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.9	%	ASTM D 638
Tensile Modulus, 50 mm/min	52200	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1220	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1220	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	45200	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	0	MPa	ISO 527
Tensile Stress, break, 5 mm/min	74	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	0	%	ISO 527
Tensile Strain, break, 5 mm/min	1.8	%	ISO 527
Tensile Modulus, 1 mm/min	5230	MPa	ISO 527
Flexural Modulus, 2 mm/min	5010	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	35	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	23	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	95	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	94	°C	ISO 75/Af
PHYSICAL			
Density	2.19	g/cm ³	ASTM D 792

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PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	1.28	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.08	%	ASTM D 955
Density	2.19	g/cm ³	ISO 1183
Melt Volume Rate, MVR at 270°C/1.2 kg	17	cm ³ /10 min	ISO 1133
ELECTRICAL			
Dissipation Factor, 900MHz	0.011	-	ASTM D 150
Relative Permittivity, 900MHz	7.9	-	ASTM D 2520 - Mth B

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	85	°C
Drying Time	8 - 10	hrs
Melt Temperature	260 - 270	°C
Nozzle Temperature	265 - 275	°C
Front - Zone 3 Temperature	265 - 270	°C
Middle - Zone 2 Temperature	265 - 270	°C
Rear - Zone 1 Temperature	255 - 260	°C
Mold Temperature	90	°C
Back Pressure	7 - 8	MPa
Screw Speed	110 - 130	rpm