



LNP™ THERMOCOMP™ Compound RF005

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound RF-1005

Product reorder name: RF005

LNP THERMOCOMP RF005 is a compound based on Nylon 66 resin containing 25% Glass Fiber.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1340	kgf/cm ²	ASTM D 638
Tensile Strain, break	1.9	%	ASTM D 638
Tensile Modulus, 50 mm/min	92800	kgf/cm ²	ASTM D 638
Flexural Stress	1960	kgf/cm ²	ASTM D 790
Flexural Modulus	73800	kgf/cm ²	ASTM D 790
Tensile Stress, break	139	MPa	ISO 527
Tensile Strain, break	2	%	ISO 527
Tensile Modulus, 1 mm/min	8300	MPa	ISO 527
Flexural Stress	205	MPa	ISO 178
Flexural Modulus	8300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	49	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	71	cm-kgf	ASTM D 3763
Multiaxial Impact	20	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	33	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	258	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	245	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	224	°C	ISO 75/Af
PHYSICAL			
Density	1.35	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.3	%	ASTM D 955



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PHYSICAL Mold Shrinkage, xflow, 24 hrs (5)	1.4	%	ASTM D 955



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	280 - 305	°C
Front - Zone 3 Temperature	295 - 305	°C
Middle - Zone 2 Temperature	280 - 295	°C
Rear - Zone 1 Temperature	265 - 275	°C
Mold Temperature	95 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm