



LNP™ THERMOCOMP™ Compound RF00469S

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound RF-1004 FR HS

Product reorder name: RF00469S

LNP THERMOCOMP RF00469S is a compound based on Nylon 66 resin containing 20% Glass Fiber. Added features of this material include: Flame Retardant, Heat Stabilized.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1390	kgf/cm ²	ASTM D 638
Tensile Strain, break	3.3	%	ASTM D 638
Flexural Stress	2030	kgf/cm ²	ASTM D 790
Flexural Modulus	76400	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	69	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	8	cm-kgf/cm	ASTM D 256
PHYSICAL			
Density	1.53	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.3 - 0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1 - 1.2	%	ASTM D 955
FLAME CHARACTERISTICS			
UL Compliant, 94V-0 Flame Class Rating (3)(4)	1.7	mm	UL 94 by SABIC-IP



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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	275 - 290	°C
Front - Zone 3 Temperature	295 - 305	°C
Middle - Zone 2 Temperature	280 - 295	°C
Rear - Zone 1 Temperature	265 - 275	°C
Mold Temperature	80 - 95	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm