



LNP™ THERMOCOMP™ Compound RX04515H

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound PDX-R-04515 EES HC

Product reorder name: RX04515H

LNP THERMOCOMP RX04515H is a compound based on Nylon 66 resin containing Proprietary Filler(s). Added features of this material include: Electrically Conductive, Healthcare.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	2830	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.6	%	ASTM D 638
Tensile Modulus, 5 mm/min	314000	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 2.6 mm/min, 100 mm span	4210	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	241600	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	99	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	255	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.33	-	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.2 - 0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955



LNP™ THERMOCOMP™ Compound RX04515H

Americas: COMMERCIAL

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