



LNP™ THERMOCOMP™ Compound RFZ349XC

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound RF-1007 FR MG LEX

Product reorder name: RFZ349XC

LNP THERMOCOMP™ RFZ349XC is a compound based on Nylon 66 resin containing 20% Glass Fiber, 15% Milled Glass. Added features of this material include: Flame Retardant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1270	kgf/cm ²	ASTM D 638
Tensile Strain, break	2.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	112400	kgf/cm ²	ASTM D 638
Flexural Stress	1820	kgf/cm ²	ASTM D 790
Flexural Modulus	73100	kgf/cm ²	ASTM D 790
Tensile Stress, break	85	MPa	ISO 527
Tensile Strain, break	3.2	%	ISO 527
Tensile Modulus, 1 mm/min	11400	MPa	ISO 527
Flexural Stress	197	MPa	ISO 178
Flexural Modulus	9000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	59	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	71	cm-kgf	ASTM D 3763
Multiaxial Impact	23	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	39	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	7	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	237	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	235	°C	ISO 75/Af
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.2	%	ASTM D 955



LNP™ THERMOCOMP™ Compound RFZ349XC

Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	0.39	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.19	%	ISO 294
Density	1.66	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.43	%	ISO 62



LNP™ THERMOCOMP™ Compound RFZ349XC

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