



## LNP™ THERMOCOMP™ Compound RF006L

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound RF-1006 LE

Product reorder name: RF006L

LNP THERMOCOMP RF006L is a compound based on Nylon 66 resin containing 30% Glass Fiber. Added features of this material include: Low Extractible.

| TYPICAL PROPERTIES <sup>1</sup>  | TYPICAL VALUE | Unit                | Standard    |
|----------------------------------|---------------|---------------------|-------------|
| <b>MECHANICAL</b>                |               |                     |             |
| Tensile Stress, break            | 1600          | kgf/cm <sup>2</sup> | ASTM D 638  |
| Tensile Strain, break            | 2.4           | %                   | ASTM D 638  |
| Tensile Modulus, 50 mm/min       | 107500        | kgf/cm <sup>2</sup> | ASTM D 638  |
| Flexural Stress                  | 2240          | kgf/cm <sup>2</sup> | ASTM D 790  |
| Flexural Modulus                 | 89000         | kgf/cm <sup>2</sup> | ASTM D 790  |
| <b>IMPACT</b>                    |               |                     |             |
| Izod Impact, unnotched, 23°C     | 76            | cm-kgf/cm           | ASTM D 4812 |
| Izod Impact, notched, 23°C       | 8             | cm-kgf/cm           | ASTM D 256  |
| <b>THERMAL</b>                   |               |                     |             |
| HDT, 1.82 MPa, 3.2mm, unannealed | 246           | °C                  | ASTM D 648  |
| <b>PHYSICAL</b>                  |               |                     |             |
| Density                          | 1.59          | g/cm <sup>3</sup>   | ASTM D 792  |
| Mold Shrinkage, flow, 24 hrs (5) | 0.4           | %                   | ASTM D 955  |



## LNP™ THERMOCOMP™ Compound RF006L

Americas: COMMERCIAL

| PROCESSING PARAMETERS       | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| 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  |