



LNP™ THERMOTUF™ Compound RF006I

Americas: COMMERCIAL

Also known as: LNP™ THERMOTUF™ Compound RF-1006 HI

Product reorder name: RF006I

LNP THERMOTUF RF006I is a compound based on Nylon 66 resin containing Glass Fiber. Added features of this material include: High Impact.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, break	1640	kgf/cm ²	ASTM D 638
Tensile Strain, break	3.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	106100	kgf/cm ²	ASTM D 638
Flexural Stress	2530	kgf/cm ²	ASTM D 790
Flexural Modulus	88500	kgf/cm ²	ASTM D 790
Tensile Stress, break	179	MPa	ISO 527
Tensile Strain, break	2.9	%	ISO 527
Tensile Modulus, 1 mm/min	10840	MPa	ISO 527
Flexural Stress	266	MPa	ISO 178
Flexural Modulus	9480	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	114	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	11	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	182	cm-kgf	ASTM D 3763
Multiaxial Impact	57	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	75	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	259	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	121	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.75E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.08E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	2.75E-05	1/°C	ISO 11359-2



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THERMAL			
CTE, -40°C to 40°C, xflow	6.08E-05	1/°C	ISO 11359-2
PHYSICAL			
Density	1.38	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.63	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.27	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.12	%	ISO 294
Density	1.37	g/cm ³	ISO 1183



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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