



LNP™ THERMOCOMP™ Compound RF0029S

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound RF-1002 FR HS

Product reorder name: RF0029S

LNP THERMOCOMP RF0029S is a compound based on Nylon 66 resin containing 10% Glass Fiber. Added features of this material include: Flame Retardant, Heat Stabilized.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1030	kgf/cm ²	ASTM D 638
Tensile Stress, break	1030	kgf/cm ²	ASTM D 638
Tensile Strain, yield	2.5	%	ASTM D 638
Tensile Strain, break	2.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	70300	kgf/cm ²	ASTM D 638
Flexural Stress	1540	kgf/cm ²	ASTM D 790
Flexural Modulus	56200	kgf/cm ²	ASTM D 790
Tensile Stress, yield	102	MPa	ISO 527
Tensile Stress, break	102	MPa	ISO 527
Tensile Strain, yield	2.4	%	ISO 527
Tensile Strain, break	2.4	%	ISO 527
Tensile Modulus, 1 mm/min	6370	MPa	ISO 527
Flexural Stress	150	MPa	ISO 178
Flexural Modulus	5900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	51	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	86	cm-kgf	ASTM D 3763
Multiaxial Impact	19	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	33	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	252	°C	ASTM D 648



LNP™ THERMOCOMP™ Compound RF0029S

Americas: COMMERCIAL

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	233	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.56E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.32E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.6E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	4.2E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	249	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	219	°C	ISO 75/Af
PHYSICAL			
Density	1.48	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.5	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.9 - 1.1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.2 - 1.4	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.98	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.3	%	ISO 294
Density	1.48	g/cm ³	ISO 1183



LNP™ THERMOCOMP™ Compound RF0029S

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	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