



## LNP™ THERMOCOMP™ Compound RF00469S

### Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound RF-1004 FR HS

Product reorder name: RF00469S

LNP THERMOCOMP RF00469S is a compound based on Nylon 66 resin containing 20% Glass Fiber. Added features of this material include: Flame Retardant, Heat Stabilized.

| TYPICAL PROPERTIES <sup>1</sup>               | TYPICAL VALUE | Unit                | Standard          |
|-----------------------------------------------|---------------|---------------------|-------------------|
| <b>MECHANICAL</b>                             |               |                     |                   |
| Tensile Stress, break                         | 1390          | kgf/cm <sup>2</sup> | ASTM D 638        |
| Tensile Strain, break                         | 3.3           | %                   | ASTM D 638        |
| Flexural Stress                               | 2030          | kgf/cm <sup>2</sup> | ASTM D 790        |
| Flexural Modulus                              | 76400         | kgf/cm <sup>2</sup> | ASTM D 790        |
| <b>IMPACT</b>                                 |               |                     |                   |
| Izod Impact, unnotched, 23°C                  | 69            | cm-kgf/cm           | ASTM D 4812       |
| Izod Impact, notched, 23°C                    | 8             | cm-kgf/cm           | ASTM D 256        |
| <b>PHYSICAL</b>                               |               |                     |                   |
| Density                                       | 1.53          | g/cm <sup>3</sup>   | ASTM D 792        |
| Mold Shrinkage, flow, 24 hrs (5)              | 0.3 - 0.5     | %                   | ASTM D 955        |
| Mold Shrinkage, xflow, 24 hrs (5)             | 1 - 1.2       | %                   | ASTM D 955        |
| <b>FLAME CHARACTERISTICS</b>                  |               |                     |                   |
| UL Compliant, 94V-0 Flame Class Rating (3)(4) | 1.7           | mm                  | UL 94 by SABIC-IP |



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| 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            | 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  |