



LNP™ THERMOCOMP™ Compound RF004XXH

Americas: COMMERCIAL

Also known as: LNP™ THERMOCOMP™ Compound RF-1004 HC

Product reorder name: RF004XXH

LNP THERMOCOMP™ RF004XXH is a compound based on Nylon 66 resin containing 20% Glass Fiber. Added feature of this grade is: Healthcare.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	1510	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.8	%	ASTM D 638
Tensile Modulus, 5 mm/min	81300	kgf/cm ²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	2370	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	72700	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	148	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.8	%	ISO 527
Tensile Modulus, 1 mm/min	7640	MPa	ISO 527
Flexural Stress	217	MPa	ISO 178
Flexural Modulus, 2 mm/min	6400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	60	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Multiaxial Impact	22	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	71	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	39	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	260	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	255	°C	ASTM D 648
CTE, -30°C to 30°C, flow	4.8E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	8.4E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	258	°C	ISO 75/Bf



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	241	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Density	1.29	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.78	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.4 - 0.6	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1 - 3	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.44	%	ISO 62



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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