

**Product Texts**

LNP THERMOCOMP RF004XXH compound is based on Nylon 6/6 resin containing 20% glass fiber. Added features of this grade include: Healthcare.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.5	mm/mm	ASTM D 955
Mold Shrinkage, TD	2	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	7640	MPa	ISO 527
Stress at break	148	MPa	ISO 527
Strain at break	2.8	%	ISO 527
Flexural modulus	6400	MPa	ISO 178
Flexural strength	217	MPa	ISO 178
Izod impact strength, +23°C, 4mm	39	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	6	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	7980	MPa	ASTM D 638
Tensile Strength at Break	149	MPa	ASTM D 638
Elongation at Break	2.8	%	ASTM D 638
Flexural Modulus	7130	MPa	ASTM D 790
Izod Impact notched, 1/8 in	74	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	593	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	241	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	258	°C	ISO 75-1/-2
<b>ASTM Data</b>			
Coefficient of Thermal Expansion, MD	48.1	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	84.1	E-6/K	ASTM D 696
DTUL @ 66 psi	260	°C	ASTM D 648
DTUL @ 264 psi	255	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Humidity absorption	0.44	%	Sim. to ISO 62
Water Absorption, 24hr	0.78	%	ASTM D 570
Density	1290	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.25	%	-
Melt temperature	280 - 305	°C	-
Mold temperature	95 - 110	°C	-
Zone 1	265 - 275	°C	-
Zone 2	280 - 295	°C	-
Zone 3	295 - 305	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific