LNP™ STAT-KON™ Compound RX10004

RX10004

DESCRIPTION

LNP STAT-KON RX10004 compound is based on Nylon 6/6 resin containing carbon fiber and 40% glass fiber. Added features of this grade include: Electrically Conductive, Easy Molding.

GENERAL INFORMATION	
Features	Electrically Conductive, Good Processability, Carbon fiber filled, High stiffness/Strength, No PFAS intentionally added
Fillers	Carbon Fiber, Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
Polymer Types	Polyamide 66 (Nylon 66)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Electrical and Electronics	Electronic Components
Industrial	Material Handling

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, yield, 5 mm/min	230	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.8	%	ISO 527
Tensile Modulus, 1 mm/min	18900	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	334	MPa	ISO 178
Flexural Modulus, 2 mm/min	16900	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched 80*10*4 +23°C	93	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
PHYSICAL [1]			
Mold Shrinkage, flow [2]	0.2 – 0.4	%	SABIC method
Density	1.54	g/cm³	ISO 1183
ELECTRICAL [1]			
Surface Resistivity [3]	1.E+05 – 1.E+07	Ω	ASTM D257
INJECTION MOLDING [4]			
Drying Temperature	120	°C	
Drying Time	4	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	305 – 325	°C	
Front - Zone 3 Temperature	320 – 330	°C	
Middle - Zone 2 Temperature	310 – 320	°C	
Rear - Zone 1 Temperature	295 – 305	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Temperature	80 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

(1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

(2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

(3) Measurement meets requirements as specified in ASTM D4496.

(4) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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