

## LNP\* Stat-kon\* Compound RFD04

Americas: COMMERCIAL

Also known as: RF-20  
Product Reorder Name: RFD04

LNP STAT-KON\* RFD04 is a compound based on Nylon 66 resin containing Carbon Powder, Glass Fiber. Added features of this material include: Electrically Conductive.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
	Value	Unit	Standard
<b>MECHANICAL</b>			
Tensile Stress, break	117	MPa	ISO 527
Tensile Strain, break	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	9250	MPa	ISO 527
Flexural Stress	197	MPa	ISO 178
Flexural Modulus	8600	MPa	ISO 178
<b>IMPACT</b>			
Izod Impact, notched 80*10*4 +23°C	4	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL</b>			
CTE, -40°C to 40°C, flow	3.22E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.46E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	248	°C	ISO 75/Af
<b>PHYSICAL</b>			
Mold Shrinkage, flow, 24 hrs	0.61	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.35	%	ISO 294
Density	1.39	g/cm <sup>3</sup>	ISO 1183
<b>ELECTRICAL</b>			
Surface Resistivity	1.E+02 - 1.E+04	Ohm	ASTM D 257

Source GMD, last updated:10/01/2004

### Processing

Parameter	Value	Unit
<b>Injection Molding</b>		
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

Source GMD, last updated:10/01/2004

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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