LNP™ LUBRICOMP™ COMPOUND RFG16

DESCRIPTION

LNP LUBRICOMP RFG16 is a compound based on PA 66 resin containing Glass Fiber, Graphite. Added features include: Internally Lubricated.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	156	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.2	%	ISO 527
Tensile Modulus, 1 mm/min	9800	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	249	MPa	ISO 178
Flexural Stress, break, 2 mm/min	249	MPa	ISO 178
Flexural Strain, break, 2 mm/min	3.8	%	ISO 178
Flexural Modulus, 2 mm/min	8700	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	60	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	2.6E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.9E-05	1/°C	ISO 11359-2
PHYSICAL			
Mold Shrinkage, flow	0.24	%	SABIC method
Density	1.4	g/cm³	ISO 1183
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	

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