LNP™ LUBRICOMP™ COMPOUND RFL22E

RFL-4022EM

DESCRIPTION

LNP LUBRICOMP RFL22E Is a compound based on PA66 resin, containing Glass Fiber and PTFE. Added features include: Internally Lubricated, Easy Moulding

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	95	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.7	%	ISO 527
Tensile Modulus, 1 mm/min	4400	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	138	MPa	ISO 178
Flexural Strain, break, 2 mm/min	4.7	%	ISO 178
Flexural Modulus, 2 mm/min	4500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	4.2E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.E-04	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	256	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	236	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.5 – 0.6	%	SABIC method
Density	1.28	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	0.93	%	ISO 62-1
FLAME CHARACTERISTICS			
Glow Wire Ignitability Temperature, 2.0 mm	675	°C	IEC 60695-2-13
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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