LNP™ LUBRICOMP™ COMPOUND RFL36SXS

DESCRIPTION

LNP LUBRICOMP RFL36SXS is a compound based on PA 66 resin containing Glass Fiber, PTFE. Added features include Internally Lubricated, Heat Stabilized.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	171	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3.1	%	ISO 527
Flexural Stress, yield, 2 mm/min	247	MPa	ISO 178
Flexural Modulus, 2 mm/min	8800	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	80	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	12	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	2.3E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.E-04	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	248	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.2	%	SABIC method
Wear Factor Washer	12	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.54	-	ASTM D 3702 Modified: Manual
Static COF	0.46	-	ASTM D 3702 Modified: Manual
Density	1.49	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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