LNP™ LUBRICOMP™ COMPOUND RFN18S

RFL-4218 HS

DESCRIPTION

LNP LUBRICOMP* RFN18S is a compound based on Nylon 66 resin containing Glass Fiber, MOS2. Added features of this material include: Heat Stabilized, Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191219

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	177	MPa	ASTM D 638
Tensile Strain, break	1.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	15510	MPa	ASTM D 638
Flexural Stress	268	MPa	ASTM D 790
Flexural Modulus	10750	MPa	ASTM D 790
Tensile Stress, break	192	MPa	ISO 527
Tensile Strain, break	2.2	%	ISO 527
Tensile Modulus, 1 mm/min	14000	MPa	ISO 527
Flexural Stress	287	MPa	ISO 178
Flexural Modulus	13100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	891	J/m	ASTM D 4812
Izod Impact, notched, 23°C	84	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	8	J	ASTM D 3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	59	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	10	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	259	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	250	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	>240	°C	ISO 75/Af
PHYSICAL			
Density	1.51	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.61	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.35	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.17	%	ISO 294
Wear Factor Washer	45	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.75	-	ASTM D 3702 Modified: Manual
Static COF	0.59	-	ASTM D 3702 Modified: Manual
Density	1.51	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	1	%	ISO 62
INJECTION MOLDING			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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