LNP™ LUBRICOMP™ COMPOUND RL0049S

RL-4040 FR HS

DESCRIPTION

LNP LUBRICOMP* RL0049S is a compound based on Nylon 66 resin containing 20% PTFE. Added features of this material include: Flame Retardant, Heat Stabilized, Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	47	MPa	ASTM D 638
Tensile Strain, break	2.2	%	ASTM D 638
Tensile Modulus, 50 mm/min	3170	MPa	ASTM D 638
Flexural Stress	77	MPa	ASTM D 790
Flexural Modulus	3090	MPa	ASTM D 790
Tensile Stress, break	46	MPa	ISO 527
Tensile Strain, break	2	%	ISO 527
Tensile Modulus, 1 mm/min	3160	MPa	ISO 527
Flexural Stress	78	MPa	ISO 178
Flexural Modulus	2970	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	170	J/m	ASTM D 4812
Izod Impact, notched, 23°C	21	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	10	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	2	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	95	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	90	°C	ISO 75/Af
PHYSICAL			
Density	1.53	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.38	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	1.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.7	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	1.52	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.67	%	ISO 294
Moisture Absorption (23°C / 50% RH)	0.55	%	ISO 62
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	275 – 290	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Middle - Zone 2 Temperature	280 – 295	°C	
Rear - Zone 1 Temperature	265 – 275	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Temperature	80 – 95	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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