LNP™ LUBRICOMP™ COMPOUND RX05495

RFL-4316 EM HS MG MR

DESCRIPTION

LNP LUBRICOMP* RX05495 is a compound based on Nylon 66 resin containing 30% Glass Bead, Graphite, Glass Fiber, 5% Graphite Powder. Added features of this material include: Easy Molding. Heat Stabilized, Mold Release, Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	117	MPa	ASTM D 638
Tensile Strain, break	2.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	7990	MPa	ASTM D 638
Flexural Stress	173	MPa	ASTM D 790
Flexural Modulus	6130	MPa	ASTM D 790
Tensile Stress, break	112	MPa	ISO 527
Tensile Strain, break	2.9	%	ISO 527
Tensile Modulus, 1 mm/min	7500	MPa	ISO 527
Flexural Stress	176	MPa	ISO 178
Flexural Modulus	7100	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	667	J/m	ASTM D 4812
Izod Impact, notched, 23°C	53	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	10	J	ASTM D 3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	45	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	255	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	233	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	229	°C	ISO 75/Af
PHYSICAL			
Density	1.38	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.84	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.46	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.5	%	ISO 294
Density	1.38	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	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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