LNP™ VERTON™ COMPOUND RVL28

RFL-8028 EM HS

DESCRIPTION

LNP VERTON RVL28 is a compound based on Nylon 66 resin containing 40% Long Glass Fiber, 10% PTFE. Added features of this material include: Easy Molding, Heat Stabilized, Wear Resistant, Structural.

TYPICAL PROPERTY VALUES

Revision 20190304

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	220	MPa	ASTM D 638
Tensile Stress, break	220	MPa	ASTM D 638
Tensile Strain, yield	2.3	%	ASTM D 638
Tensile Strain, break	2.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	14470	MPa	ASTM D 638
Flexural Stress	337	MPa	ASTM D 790
Flexural modulus	12200	MPa	ASTM D 790
Tensile Stress, yield	228	MPa	ISO 527
Tensile Stress, break	228	MPa	ISO 527
Tensile Strain, yield	2.4	%	ISO 527
Tensile Strain, break	2.4	%	ISO 527
Tensile Modulus, 1 mm/min	13230	MPa	ISO 527
Flexural Stress	351	MPa	ISO 178
Flexural Modulus	13000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1409	J/m	ASTM D 4812
Izod Impact, notched, 23°C	265	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	14	J	ASTM D 3763
Multiaxial Impact	7	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	93	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	23	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	256	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	252	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.86E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	2.16E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.9E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	2.1E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	255	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	259	°C	ISO 75/Af
PHYSICAL			
Density	1.57	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.5	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.4	%	ASTM D 955

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, xflow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.33	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.77	%	ISO 294
Density	1.57	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	290 – 305	°C	
Front - Zone 3 Temperature	290 – 300	°C	
Middle - Zone 2 Temperature	290 – 300	°C	
Rear - Zone 1 Temperature	280 – 295	°C	
Mold Temperature	95 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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