LNP™ VERTON™ COMPOUND RVL36SXS

RFL-8036

DESCRIPTION

LNP VERTON RVL36SXS is a compound based on PA 66 resin containing Long Glass Fiber, PTFE. Added features include; Internally Lubricated.

TYPICAL PROPERTY VALUES

Revision 20190308

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	185	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.3	%	ISO 527
Tensile Modulus, 1 mm/min	11200	MPa	ISO 527
Flexural Stress, break, 2 mm/min	275	MPa	ISO 178
Flexural Modulus, 2 mm/min	9300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	70	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	33	kJ/m²	ISO 180/1A
THERMAL			
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	265	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	261	°C	ISO 75/Af
PHYSICAL			
Density	1.53	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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