

## LNPTM LUBRICOMPTM COMPOUND RFL33

RFL-4033

## **DESCRIPTION**

LNP LUBRICOMP RFL33 compound is based on Nylon 6/6 resin containing 15% glass fiber, 15% PTFE. Added features of this grade include: Wear Resistant.

GENERAL INFORMATION	
Features	Wear resistant
Fillers	Glass Fiber, PTFE
Polymer Types	Polyamide 66 (Nylon 66)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

## **TYPICAL PROPERTY VALUES**

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL (1)			
Tensile Modulus, 5 mm/min	6890	MPa	ASTM D638
Tensile Stress, break	119	MPa	ASTM D638
Tensile Strain, break	3.1	%	ASTM D638
Flexural Stress	179	MPa	ASTM D790
Flexural Modulus	5510	MPa	ASTM D790
Tensile Modulus, 1 mm/min	6200	MPa	ISO 527
Tensile Stress, break, 5 mm/min	122	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3.5	%	ISO 527
Flexural Modulus, 2 mm/min	5200	MPa	ISO 178
Flexural Strength, 2 mm/min	178	MPa	ISO 178
IMPACT (1)			
Izod Impact, unnotched, 23°C	571	J/m	ASTM D4812
Izod Impact, notched, 23°C	64	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	7	J	ASTM D3763
Multiaxial Impact	2	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	35	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL (1)			
HDT, 0.45 MPa, 3.2 mm, unannealed	261	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	247	°C	ASTM D648
CTE, -40°C to 40°C, flow	3.9E-05	1/°C	ASTM E831
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PROPERTIES         TYPICAL VALUES         UNITS         TEST METHODS           CTE, 40°Ct 040°C, falow         3.81°G3         1,°C         ASTM R831           CTE, 40°Ct 040°C, falow         3.96°G3         1,°C         SD 1359-92           CTE, 23°Ct 060°C, falow         3.96°G3         1,°C         SD 1359-92           CTE, 23°Ct 060°C, falow         95.05°S         1,°C         SD 1359-92           HDTJAI, 1.81 Mira Flatw 80°10°4 spe-64mm         26         °C         SD 75 /M           HDTJAI, 1.81 Mira Flatw 80°10°4 spe-64mm         23         °C         U.7468           HDTJAI, 1.81 Mira Flatw 80°10°4 spe-64mm         26         °C         U.7468           Relative Temp Index, Mech w/Impact (°         65         °C         U.7468           Relative Temp Index, Mech w/Impact (°)         65         °C         W.7468           Relative Temp Index, Mech w/Impact (°)         65         °C         W.7468           Relative Temp Index, Mech w/Impact (°)         65         °C         ASTM D952           Relative Temp Index, Mech w/Impact (°)         66         %         ASTM D952           Wells (*)         40         *M         ASTM D952           Wells (*)         50         *M         ASTM D952           We				
CF. 40°Cto 40°C, 160w         35.05         1°C         10°C         10°1359.2           CF. 40°Cto 40°C, 160w         8.85.05         1°C         10°L         10°1359.2           CF. 23°Cto 60°C, 160w         9.50.5         1°C         50°1359.2           CF. 23°Cto 60°C, 160w         9.50.5         1°C         50°75/8           HDT/B, 0.45 MPa Flatw 80°10°4 sp=64mm         26         0°C         10°75/8           Relative Temp Index, Mech w/Impact <sup>(2)</sup> 50°         °C         10°74/8           Relative Temp Index, Mech w/Impact <sup>(2)</sup> 50°         °C         10°74/8           Relative Temp Index, Mech w/Impact <sup>(2)</sup> 50°         °C         10°74/8           Relative Temp Index, Mech w/Impact <sup>(3)</sup> 50°         °C         10°74/8           Relative Temp Index, Mech w/Impact <sup>(3)</sup> 50°         °C         10°74/8           Relative Temp Index, Mech w/Impact <sup>(3)</sup> 50°         °C         10°74           Relative Temp Index, Mech w/Impact <sup>(3)</sup> 50°         °C           Webstack 10°         10°         9°         N°           Mol Strinkinge, Mov. 24 hr <sup>(3)</sup> 10°         9°         N°           Mold Strinkage, Mov. 24 hr <sup>(3)</sup> 10°         10°         N°     <	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CFL, 40°C to 40°C, vilow         83-60         1°C         SC 1139-92           CFL, 23°C to 60°C, flow         95-05         1°C         SC 1139-92           HDT JRL, 0.45 MPs Patav 80°10°4 sp=64mm         260         1°C         SC 75 JRI           HDT JRL, 1.5 MPs Patav 80°10°4 sp=64mm         260         °C         U 7468           HDT JRL, 1.5 MPs Patav 80°10°4 sp=64mm         65         °C         U 7468           Relative Temp Index, Mech yimpact <sup>10</sup> 65         °C         U 7468           Relative Temp Index, Mech yimpact <sup>10</sup> 65         °C         U 7468           Relative Temp Index, Mech yimpact <sup>10</sup> 50         °C         U 7468           Relative Temp Index, Mech yimpact <sup>10</sup> 65         °C         U 7468           Relative Temp Index, Mech yimpact <sup>10</sup> 50         °C         W 7468           Relative Temp Index, Mech yimpact <sup>10</sup> 60         °C         W 7476           Relative Temp Index, Mech yimpact <sup>10</sup> 60         °C         A 87M D792           Websty Statistic Vision (19)         60         9C         A 87M D792           Mold Shrinkage, flow, 24 hrs <sup>10</sup> 60         4         A 87M D792           Static Cor         60         A 92         A 87M D792	CTE, -40°C to 40°C, xflow	8.3E-05	1/°C	ASTM E831
CTE, 23°Cto 60°C, vilow         3,960         1°C         1801 1359-2           CTE, 23°Cto 60°C, vilow         55.695         1°C         1801 1359-2           DTD/B/ 0.45 MPs latus 80°10°4 sp=64mm         243         °C         1807 5/B           Relative Temp Index, Mech w/Impact (°C)         120         °C         U.7468           Relative Temp Index, Mech w/Impact (°C)         50         °C         U.7468           Relative Temp Index, Mech w/Impact (°C)         50         °C         U.7468           Relative Temp Index, Mech w/Impact (°C)         50         °C         U.7468           Relative Temp Index, Mech w/Impact (°C)         50         °C         W.7500           Relative Temp Index, Mech w/Impact (°C)         50         SC         ASIM D870           Mols Shrinkage, Mow, 24 kns (°C)         137         SC         ASIM D870           Mold Shrinkage, 160w, 24 kns (°C)         16-18         \$C         ASIM D870           Mold Shrinkage, 160w, 24 kns (°C)         16-18         \$C         ASIM D870           Mold Shrinkage, 160w, 24 kns (°C)         16-18         \$C         ASIM D870           Mold Shrinkage, 160w, 24 kns (°C)         16-18         \$C         ASIM D870           Mold Shrinkage, 160w, 24 kns (°C)         20         ASI	CTE, -40°C to 40°C, flow	3.9E-05	1/°C	ISO 11359-2
CF 23°C to 60°C, xflow         95.050         1/°C         100 18.03 5.07 5/8 1.03 5.07 5/	CTE, -40°C to 40°C, xflow	8.3E-05	1/°C	ISO 11359-2
HDT/BI, 0.45 MPa Flatw 80°10°4 sp=64mm         260         °C         10.75 /R /A           HDT/AI, 1.8 MPa Flatw 80°10°4 sp=64mm         243         °C         0.75 /R /A           Relative Temp Index, Rech (°C)         65         °C         0.74 68           Relative Temp Index, Mech (wijmpact (°C)         65         °C         0.74 68           Relative Temp Index, Mech (wijmpact (°C)         55         °C         0.74 68           Not Struck (°C)         3.75         7.05 (°C)         0.74 68           Notiture Absorption (1,23°C) (50% RH) 24 hrs)         6.6         \$         ASTM D570           Mold Shrinkage, How, 24 hrs (°C)         5.6 - 0.7         \$         ASTM D575           Mold Shrinkage, How, 24 hrs (°C)         5.6 - 0.7         \$         ASTM D575           Mold Shrinkage, How, 24 hrs (°C)         5.6 - 0.8         \$         ASTM D575           Mold Shrinkage, How, 24 hrs (°C)         1.7         \$         \$         ASTM D575           Mold Shrinkage, How, 24 hrs (°C)         1.9         \$         ASTM D570         ASTM D570           Mold Shrinkage, How, 24 hrs (°C)         1.0         \$         ASTM D3702 Modified: Manual D470         ASTM D3702 Modified: Manual D470         ASTM D3702 Modified: Manual D4702 Modified: Manual D4702 Modified: Manual D4702 Modified: Manual D4702 Modifi	CTE, 23°C to 60°C, flow	3.9E-05	1/°C	ISO 11359-2
HDT/AL 1.8 MPa Flatw 90*10*4 sp=64mm         243         "C         10.7 (AF)           Relative Temp Index, Belec <sup>(2)</sup> 120         "C         10.7 (AF)           Relative Temp Index, Mech w/ (impact <sup>(2)</sup> )         65         "C         10.7 (AF)           Relative Temp Index, Mech w/ (impact <sup>(2)</sup> )         55         "C         10.7 (AF)           Portsylock         "F         V         V           Desisty         1.37         Mol Sm.         ASTM D572           Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 50         50         2.0         3         Mol Sm.         ASTM D572           Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 6.6         3         3         ASTM D572         ASTM D572           Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 6.6         4         3         ASTM D572         ASTM D572           Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 1.7         2         4         SM D3702 Modifier Monual         Mol Sm.         ASTM D3702 Modifier Monual         Mol Sm.         ASTM D3702 Modifier Monual         Mol Sm.         Mol Sm.         ASTM D3702 Modifier Monual         Mol Sm.         Mol Sm.         ASTM D3702 Modifier Monual         Mol Sm.         Mol Sm.         Mol Sm.         ASTM D3702 Modifier Monual         Mol Sm.         Mol Sm.         Mol Sm.<	CTE, 23°C to 60°C, xflow	9.5E-05	1/°C	ISO 11359-2
Relative Temp Index, Elec <sup>(1)</sup> 120         "C         U.7468           Relative Temp Index, Mech w/ impact <sup>(2)</sup> 65         "C         U.7468           Relative Temp Index, Mech w/ impact <sup>(2)</sup> 55         "C         U.7468           Privication           Emity         Jan.         Jan.         Jan.         ASM D792           Moisture Absorption (23°C/50°RH/24 hrs)         6.6         3         ASM D792           Moisture Absorption (23°C/50°RH/24 hrs)         6.6         4         ASM D792           Moisture Absorption (23°C/50°RH/24 hrs)         6.6         4         ASM D792           Moisture Absorption (23°C/50°RH/24 hrs)         6.6         4         ASM D792         ASM D792           Moid Shrinkage, flow, 24 hrs <sup>(2)</sup> 4         6         9         9         9           Moid Shrinkage, flow, 24 hrs <sup>(2)</sup> 4         9         9         9         9         9         9         9         9         9 </td <td>HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm</td> <td>260</td> <td>°C</td> <td>ISO 75/Bf</td>	HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	260	°C	ISO 75/Bf
Relative Temp Index, Mech w/ Impact (2)65CCCCRelative Temp Index, Mech w/ Impact (2)65CCCCPHYSICAL (1)FFCCCCCDenix (2)503ASIM D792CASIM D792Moisture Absorption (22°C/50% RH/24 Nr)668ASIM D795Moid Shrinkage, flow, 24 hrs (1)668ASIM D795Moid Shrinkage, flow, 24 hrs (1)6689ASIM D3702 Modified: Manual D194Moid Shrinkage, flow, 24 hrs (1)6910101010Moid Shrinkage, flow, 24 hrs (1)19101010101010Moid Shrinkage, flow, 24 hrs (1)1910 <th< td=""><td>HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm</td><td>243</td><td>°C</td><td>ISO 75/Af</td></th<>	HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	243	°C	ISO 75/Af
Relative Temp Index, Mechay in prior (I)1515161	Relative Temp Index, Elec <sup>(2)</sup>	120	°C	UL 746B
Power Colspan="3">Name of Colspan="3">	Relative Temp Index, Mech w/impact (2)	65	°C	UL 746B
Denity137grandASTM 10792Moisture Absorption, C3°C (50% RH/24 hrs)163335M 10570Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 10955Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 2094Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 2094Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 2094Mold Shrinkage, flow, 24 hrs (1)16-1.8333Mold Shrinkage, flow, 24 hrs (1)16-1.83333Mold Shrinkage, flow, 24 hrs (1)16-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83 <t< td=""><td>Relative Temp Index, Mech w/o impact (2)</td><td>65</td><td>°C</td><td>UL 746B</td></t<>	Relative Temp Index, Mech w/o impact (2)	65	°C	UL 746B
Denity137grandASTM 10792Moisture Absorption, C3°C (50% RH/24 hrs)163335M 10570Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 10955Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 2094Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 2094Mold Shrinkage, flow, 24 hrs (1)16-1.83335M 2094Mold Shrinkage, flow, 24 hrs (1)16-1.8333Mold Shrinkage, flow, 24 hrs (1)16-1.83333Mold Shrinkage, flow, 24 hrs (1)16-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83333Mold Shrinkage, flow, 24 hrs (1)25-1.83 <t< td=""><td>PHYSICAL (1)</td><td></td><td></td><td></td></t<>	PHYSICAL (1)			
Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 50.7%%MolD 955Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 161.8%%ASTM D955Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 0.64%%9Mold Shrinkage, flow, 24 hrs <sup>(3)</sup> 1.7%%9More Factor Washer1910-10 in/3-min/fi-libraASTM D3702 Modified: ManualDynamic COF0.391.7ASTM D3702 Modified: ManualBasic COF1.36yonaASTM D3702 Modified: ManualBestive CHARACTERITICS1.36yona1.50 mol 20 m		1.37	g/cm³	ASTM D792
Mold Shrinkage, rilow, 24 hrs (3)1.6 - 1.8\$ACTM D956Mold Shrinkage, rilow, 24 hrs (3)1.7\$\$\$Wear Factor Washer1.7\$\$\$\$Dynamic COF.039.0.0ACTM D3702 Modified: ManualStatic COF.05.0.0ACTM D3702 Modified: ManualDensity.0.0.0.0ACTM D3702 Modified: ManualDensity.0.0.0.0ACTM D3702 Modified: ManualCHAME CRESTICE (8).0.0.0.0Uyellow Card Link 2.0.0.0.0Uyellow Card Link 2.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 4.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 4.0.0.0.0Uyellow Card Link 5.0.0.0.0Uyellow Card Link 6.0.0.0.0Uyellow Card Link 5.0.0.0.0Uyellow Card Link 5.0.0.0Uyellow Card Link 5.0.0.0Uyellow Card Link 6.0.0.0Uyellow Card Link 5.0.0.0Uyellow Card Link 6.0.0.0Uyellow Card Link 6 <td>Moisture Absorption, (23°C/50% RH/24 hrs)</td> <td>0.6</td> <td></td> <td>ASTM D570</td>	Moisture Absorption, (23°C/50% RH/24 hrs)	0.6		ASTM D570
Mold Shrinkage, rilow, 24 hrs (3)1.6 - 1.8\$ACTM D956Mold Shrinkage, rilow, 24 hrs (3)1.7\$\$\$Wear Factor Washer1.7\$\$\$\$Dynamic COF.039.0.0ACTM D3702 Modified: ManualStatic COF.05.0.0ACTM D3702 Modified: ManualDensity.0.0.0.0ACTM D3702 Modified: ManualDensity.0.0.0.0ACTM D3702 Modified: ManualCHAME CRESTICE (8).0.0.0.0Uyellow Card Link 2.0.0.0.0Uyellow Card Link 2.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 4.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 3.0.0.0.0Uyellow Card Link 4.0.0.0.0Uyellow Card Link 5.0.0.0.0Uyellow Card Link 6.0.0.0.0Uyellow Card Link 5.0.0.0.0Uyellow Card Link 5.0.0.0Uyellow Card Link 5.0.0.0Uyellow Card Link 6.0.0.0Uyellow Card Link 5.0.0.0Uyellow Card Link 6.0.0.0Uyellow Card Link 6 <td>Mold Shrinkage, flow, 24 hrs <sup>(3)</sup></td> <td>0.5 – 0.7</td> <td>%</td> <td>ASTM D955</td>	Mold Shrinkage, flow, 24 hrs <sup>(3)</sup>	0.5 – 0.7	%	ASTM D955
Mold Shrinkage, flow, 24 hrs (3)9.64%50.94Mold Shrinkage, xflow, 24 hrs (3)1.7%3.72.7Wear Factor Washer1.91.01.01.01.01.0Opamic COF2.92.02.01.01.02.0Batic COF2.03.02.03.13.13.1Desity1.23.23.03.13.13.1EALE CHARACTERISTICS (2)3.13.13.13.13.1U. Yellow Card Link2.02.02.03.13.1U. Yellow Card Link 22.02.03.13.13.1U. Yellow Card Link 32.03.23.13.13.1U. Yellow Card Link 32.03.13.13.13.1U. Yellow Card Link 33.23.13.13.13.1U. Yellow Card Link 33.23.13.13.13.13.1U. Yellow Card Link 33.23.13.13.13.1U. Yellow Card Link 33.23.13.13.13.13.1U. Yellow Card Link 33.13.13.13.13.13.13.1U. Yellow Card Link 33.13.	Mold Shrinkage, xflow, 24 hrs (3)	1.6 – 1.8	%	ASTM D955
Mold Shrinkae, xflow, 24 hrs (3)1.7%\$0.2 had 10.0		0.64	%	ISO 294
Wear Factor Washer1910-10 in-15 min/It-15 minATM D3702 Modified: ManualDynamic COF0.392ATM D3702 Modified: ManualStatic COF1.503 mon3 monBonshity1.503 mon3 monBU Yellow Card Link1.21562-10134461023 monU Yellow Card Link 22.20738-1013282843 mon3 monU Yellow Card Link 32.502.502.50U Yellow Card Link 3		1.7	%	ISO 294
Dynamic COF0.99.9ATM D3702 Modified: ManualStatic COF0.45.9.3Desity1.36.9.9.30 183IAME CHARACTERISTICS (2)U. Vellow Card Link£121562-101344610.9.9.9U. Vellow Card Link 2£207780-101282824.9.9.9U. Vellow Card Link 3£329-101344595.9.9.9U. Recognized, 94HB Flame Class Rating.9.9.9.9Dying Temperature80°C.9.9Dying Time44.9.9.9.9Maximum Moisture Content.9.9.9.9May Tourne Sate Preparture.9.9.9.9Font - Zone 3 Temperature.9.9.9.9Midle-Zone 2 Temperature.9.9.9.9Rear-Zone 1 Temperature.9.9.9.9Mol Temperature.9.9.9.9Bok Pressure.9.9.9.9Mol Temperature.9.9.9.9Bok Pressure.9.9.9.9Bok Pressure.9 <td></td> <td>19</td> <td>10^-10 in^5-min/ft-lb-hr</td> <td>ASTM D3702 Modified: Manual</td>		19	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified: Manual
DesistyJohn 183FLAME CHARACTERISTICS (2)Ut Yellow Card LinkE121562-101344610	Dynamic COF	0.39		
FLAME CHARACTERISTICS (2)  UL Yellow Card Link 1	Static COF	0.45		ASTM D3702 Modified: Manual
UL Yellow Card Link 2         E207780-101282824         -	Density	1.36	g/cm³	ISO 1183
UL Yellow Card Link 2         E207780-101282824         -	FLAME CHARACTERISTICS (2)			
LY Yellow Card Link 2 LY Yellow Card Link 3 LY Recognized, 94HB Flame Class Rating  LY Yellow Card Link 3 LY Y		E121562-101344610		
DL Recognized, 94HB Flame Class Rating  DIVECTION MOLDING (4)  Drying Temperature  Drying Time  Maximum Moisture Content  Melt Temperature  280 - 305  Melt Temperature  280 - 295  Melt Temperature  280 - 295  Melt Temperature  380 - 295  Melt Tempe	UL Yellow Card Link 2			
Di Recognized, 94HB Flame Class Rating  20.75  MIECTION MOLDING (*)  Tyring Temperature  80  80  C  C  Tyring Time  10.5 – 0.25  Molt Temperature  20.7 – 0	UL Yellow Card Link 3	E45329-101344595		
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         MPa	UL Recognized, 94HB Flame Class Rating	≥0.75	mm	UL 94
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         MPa	INJECTION MOLDING (4)			
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         MPa		80	°C	
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				
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				
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	Melt Temperature	280 – 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	·		°C	
Rear - Zone 1 Temperature         265 - 275         °C           Mold Temperature         95 - 110         °C           Back Pressure         0.2 - 0.3         MPa	·			
Mold Temperature         95 – 110         °C           Back Pressure         0.2 – 0.3         MPa			°C	
			°C	
Screw Speed         30 – 60         rpm	Back Pressure	0.2 – 0.3	MPa	
	Screw Speed	30 – 60	rpm	

<sup>(1)</sup> The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.

<sup>(2)</sup> UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

<sup>(3)</sup> Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

<sup>(4)</sup> Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.



## **DISCLAIMER**

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.