LNP™ LUBRICOMP™ Compound RX05495

RFL-4316 EM HS MG MR

DESCRIPTION

LNP LUBRICOMP RX05495 compound is based on Nylon 6/6 resin containing 30% glass bead, glass fiber and 5% graphite powder. Added features of this grade include: Easy Molding, Heat Stabilized, Mold Release, Wear Resistant.

GENERAL INFORMATION	
Features	Good Processability, Heat Stabilized, Wear resistant, Enhanced mold release, Dimensional stability, No PFAS intentionally added
Fillers	Glass Bead, Graphite, Glass Fiber (Total fluorine >50ppm only from inorganic fluorine)
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 20240715

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL [1]			
Tensile Stress, break	117	MPa	ASTM D638
Tensile Strain, break	2.8	%	ASTM D638
Tensile Modulus, 50 mm/min	7990	MPa	ASTM D638
Flexural Stress	173	MPa	ASTM D790
Flexural Modulus	6130	MPa	ASTM D790
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 [1]			
Izod Impact, unnotched, 23°C	667	J/m	ASTM D4812
Izod Impact, notched, 23°C	53	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	10	J	ASTM D3763
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 [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	255	°C	ASTM D648

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT, 1.82 MPa, 3.2mm, unannealed	233	°C	ASTM D648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	229	°C	ISO 75/Af
PHYSICAL [1]			
Density	1.38	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.84	%	ASTM D570
Mold Shrinkage, flow, 24 hrs [2]	0.5	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs [2]	1.5	%	ASTM D955
Mold Shrinkage, flow, 24 hrs [2]	0.46	%	ISO 294
Mold Shrinkage, xflow, 24 hrs [2]	1.5	%	ISO 294
Density	1.38	g/cm³	ISO 1183
INJECTION MOLDING [3]			
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	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

(1) 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.

(2) 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.

(3) 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.

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