

LNPTTM LUBRICOMPTM COMPOUND RX05050

RCAL-4024

DESCRIPTION

LNP LUBRICOMP RX05050 compound is based on Nylon 6/6 resin containing 10% PTFE, 10% aramid fiber and 10% carbon fiber. Added features of this grade include: Electrically Conductive, Wear Resistant.

GENERAL INFORMATION	
Features	Electrically Conductive, Wear resistant
Fillers	Carbon Fiber, Aramid 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 Stress, break, 5 mm/min	129	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3.3	%	ISO 527
Tensile Modulus, 1 mm/min	8700	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	187	MPa	ISO 178
Flexural Modulus, 2 mm/min	7200	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, unnotched 80*10*4 +23°C	35	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
CTE, 23°C to 60°C, flow	2.4E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	8.8E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	258	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	238	°C	ISO 75/Af
PHYSICAL ⁽¹⁾			
Mold Shrinkage on Tensile Bar, flow ⁽²⁾	0.5 – 0.9	%	SABIC method
Density	1.27	g/cm ³	ISO 1183
ELECTRICAL ⁽¹⁾			
Surface Resistivity	1.E+03 – 1.E+05	Ω	ASTM D257
INJECTION MOLDING ⁽³⁾			
Drying Temperature	80	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	40	Hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	275 – 290	°C	
Rear - Zone 1 Temperature	265 – 275	°C	
Middle - Zone 2 Temperature	280 – 295	°C	
Front - Zone 3 Temperature	295 – 305	°C	
Mold Temperature	80 – 95	°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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