

LNP™ LUBRICOMP™ RX94033 compound

Polyamide 66

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP RX94033 is a compound based on PA 66 resin containing Aramid Fiber, Glass Fiber, PTFE. Added features include: Internally Lubricated.

General Information			
Filler / Reinforcement	Aramid Fiber		
	Glass Fiber		
Additive	PTFE Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.40 to 0.60	%	Internal Method
Water Absorption (23°C, 24 hr)	0.81	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	6300	MPa	ISO 527-2/1
Tensile Stress (Break)	117	MPa	ISO 527-2/5
Tensile Strain (Break)	3.8	%	ISO 527-2/5
Flexural Modulus ¹	5300	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	168	MPa	
-- ⁴	167	MPa	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵ (23°C)	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁶ (23°C)	45	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed, 64.0 mm Span	255	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	232	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	4.2E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.0E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	

Rear Temperature	266 to 277	°C
Middle Temperature	282 to 293	°C
Front Temperature	293 to 304	°C
Processing (Melt) Temp	277 to 288	°C
Mold Temperature	82.2 to 93.3	°C
Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm

NOTE

1.	2.0 mm/min
2.	2.0 mm/min
3.	Yield
4.	Break
5.	80*10*4
6.	80*10*4
7.	80*10*4 mm

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