

LNP™ LUBRICOMP™ RFP36L compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* RFP36L is a compound based on Nylon 66 resin containing 30% Glass Fiber, 15% PTFE/Silicone. Added features of this grade include: Low Extractable, Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound RFL-4536 LE

Product reorder name: RFP36L

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	PTFE + Silicone Lubricant (15%)		
Features	Good Wear Resistance		
	Low Extractables		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Molding Shrinkage			
Flow : 24 hr	0.60	%	ASTM D955
Across Flow	1.5	%	Internal Method
Water Absorption			
24 hr, 50% RH	0.69	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.47	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	10200	MPa	ASTM D638
--	10300	MPa	ISO 527-2/1
Tensile Strength			
Break ²	150	MPa	ASTM D638
Break	150	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.3	%	ASTM D638
Break	2.4	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	9660	MPa	ASTM D790
-- ⁵	9140	MPa	ISO 178
Flexural Stress			
--	214	MPa	ISO 178
Break, 50.0 mm Span ⁶	219	MPa	ASTM D790

Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.52		
vs. Itself - Static	0.50		
Wear Factor			ASTM D3702 Modified
Ring	3.90	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	27.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C ⁷	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	750	J/m	ASTM D4812
23°C ⁸	52	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	7.48	J	ASTM D3763
--	2.20	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	261	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	259	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	253	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	249	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	2.5E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.6E-5	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	282 to 304	°C	
Mold Temperature	93.3 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		

6.	1.3 mm/min
7.	80*10*4
8.	80*10*4
9.	80*10*4 mm
10.	80*10*4 mm

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