

LNP™ LUBRILOY™ RF203AXH compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP LUBRILOY RF203AXH is a compound based on Nylon 66 resin containing 15% Glass Fiber, Proprietary Lubricant. Added features of this material include: Wear Resistant, Healthcare.

Also known as: LNP* LUBRILOY* Compound RF-15 HC

Product reorder name: RF203AXH

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Additive	Lubricant		
Features	Good Wear Resistance		
	Lubricated		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.12	g/cm ³	ASTM D792
--	1.13	g/cm ³	ISO 1183, ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.80 to 1.0	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.40	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.60	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			ASTM D638
-- ¹	5040	MPa	
-- ²	4890	MPa	
Tensile Strength			
Break ³	87.0	MPa	ASTM D638
Break	90.0	MPa	ISO 527-2/5
Tensile Elongation			
Break ⁴	3.7	%	ASTM D638
Break	3.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁵	4180	MPa	ASTM D790
-- ⁶	5500	MPa	ISO 178
Flexural Stress			

--	140	MPa	ISO 178
Yield, 50.0 mm Span ⁷	136	MPa	ASTM D790
Break, 50.0 mm Span ⁸	128	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
	0.37		
vs. Itself - Dynamic	0.36		
	0.40		
vs. Itself - Static	0.30		
Wear Factor			ASTM D3702 Modified
Ring	3.00	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
	44.0		
Washer	70.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	83	J/m	ASTM D256
23°C ⁹	9.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	650	J/m	ASTM D4812
23°C ¹⁰	30	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	11.0	J	ASTM D3763
--	2.80	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	252	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	244	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	238	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	232	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	5.6E-5	cm/cm/°C	
Transverse : -30 to 30°C	1.0E-6	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	271 to 282	°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.	5.0 mm/min
2.	50 mm/min
3.	Type I, 5.0 mm/min
4.	Type I, 5.0 mm/min
5.	1.3 mm/min
6.	2.0 mm/min
7.	1.3 mm/min
8.	1.3 mm/min
9.	80*10*4
10.	80*10*4
11.	80*10*4 mm
12.	80*10*4 mm

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