

LNP™ VERTON™ RVL29ESS compound

Polyamide 66

SABIC Innovative Plastics Europe

Message:

LNP VERTON RVL29ESS is a compound based on PA 66 resin, containing Long Glass Fiber, PTFE. Added features include; Internally Lubricated.

Also known as: LNP* VERTON* Compound RFL-8029

Product reorder name: RVL29ESS

General Information			
Filler / Reinforcement	Long Glass Fiber		
Additive	PTFE Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 24 hr	0.48	%	
Flow : 24 hr	0.13	%	
Water Absorption			ISO 62
23°C, 24 hr	1.2	%	
Equilibrium, 23°C, 50% RH	0.46	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	231	MPa	ISO 527-2/5
Tensile Strain (Break)	2.3	%	ISO 527-2/5
Flexural Modulus ¹			ISO 178
--	13600	MPa	
60°C	11700	MPa	
100°C	10500	MPa	
150°C	9000	MPa	
200°C	8900	MPa	
Flexural Stress			ISO 178
--	361	MPa	
60°C	300	MPa	
100°C	256	MPa	
150°C	204	MPa	
200°C	162	MPa	
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.39		
vs. Itself - Static	0.40		
Flexural Strain at Break ²			ISO 178

--	3.2	%	
60°C	3.6	%	
100°C	3.2	%	
150°C	3.5	%	
200°C	2.7	%	
Wear Factor - Washer	21.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength			ISO 180/1A
-40°C ³	28	kJ/m ²	
23°C ⁴	30	kJ/m ²	
Unnotched Izod Impact Strength ⁵			ISO 180/1U
-40°C	74	kJ/m ²	
23°C	82	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁶ (1.8 MPa, Unannealed, 64.0 mm Span)	258	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.1E-5	cm/cm/°C	
Transverse : 23 to 60°C	4.9E-5	cm/cm/°C	
Specific Heat	1480	J/kg/°C	ASTM E1269
Thermal Conductivity	0.27	W/m/K	ASTM D5930
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15 to 0.25	%	
Rear Temperature	282 to 293	°C	
Middle Temperature	288 to 299	°C	
Front Temperature	288 to 299	°C	
Processing (Melt) Temp	288 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.	2.0 mm/min		
2.	2 mm/min		
3.	80*10*3		
4.	80*10*4		
5.	80*10*4		
6.	80*10*4 mm		

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