

LNP™ LUBRICOMP™ RL004 compound

Polyamide 66
SABIC Innovative Plastics

Message:

LNP LUBRICOMP RL004 is a copmpound based on Nylon 66 resin containing 20% PTFE. Added feature of this grade includes: Wear Resistant.
Also known as: LNP* LUBRICOMP* Compound RL-4040
Product reorder name: RL004

General Information			
UL YellowCard	E121562-101282879		
Additive	PTFE Lubricant (20%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	1.0 to 3.0	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.79	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.2	%	ISO 62
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness			ASTM D785
M-Scale	56		
R-Scale	110		
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3210	MPa	ASTM D638
--	3060	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	71.0	MPa	ASTM D638
Yield	69.0	MPa	ISO 527-2/5
Break ³	71.0	MPa	ASTM D638
Break	69.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	6.4	%	ASTM D638
Yield	7.7	%	ISO 527-2/5
Break ⁵	6.7	%	ASTM D638
Break	8.0	%	ISO 527-2/5

Flexural Modulus			
50.0 mm Span ⁶	2680	MPa	ASTM D790
-- ⁷	2730	MPa	ISO 178
Flexural Stress	90.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.32		
vs. Itself - Static	0.21		
Wear Factor - Washer	16.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	35	J/m	ASTM D256
23°C ⁸	3.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	600	J/m	ASTM D4812
23°C ⁹	36	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	4.20	J	ASTM D3763
--	1.20	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	239	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	201	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	71.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	68.0	°C	ISO 75-2/Af
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.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		

7.	2.0 mm/min
8.	80*10*4
9.	80*10*4
10.	80*10*4 mm
11.	80*10*4 mm

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