

LNP™ LUBRICOMP™ RFL46 compound

Polyamide 66

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP RFL46 is a compound based on PA66 resin containing Glass Fiber, PTFE. Added features include: Internally Lubricated.

Also known as: LNP* LUBRICOMP* Compound RFL-4046

Product reorder name: RFL46

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	PTFE Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.24	g/cm ³	ISO 1183
Molding Shrinkage - Flow ¹	1.8 to 2.3	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2500	MPa	ISO 527-2/1
Tensile Stress (Break)	53.0	MPa	ISO 527-2/5
Tensile Strain (Break)	4.9	%	ISO 527-2/5
Flexural Modulus ²	2200	MPa	ISO 178
Flexural Stress	81.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 64.0 mm Span	203	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	72.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	9.6E-5	cm/cm/°C	
Transverse : 23 to 60°C	9.6E-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.	Tensile Bar	
2.	2.0 mm/min	
3.	80*10*4	
4.	80*10*4	
5.	80*10*4 mm	

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