

LNP™ VERTON™ RVL28 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP VERTON RVL28 is a compound based on Nylon 66 resin containing 40% Long Glass Fiber, 10% PTFE. Added features of this material include: Easy Molding, Heat Stabilized, Wear Resistant, Structural.

Also known as: LNP* VERTON* Compound RFL-8028 EM HS

Product reorder name: RVL28

General Information			
Filler / Reinforcement	Long Glass Fiber,40% Filler by Weight		
Additive	Heat Stabilizer		
	PTFE Lubricant (10%)		
Features	Good Moldability		
	Good Wear Resistance		
	Heat Stabilized		
	Lubricated		
Uses	Structural Parts		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.58	g/cm ³	ASTM D792
--	1.57	g/cm ³	ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.20 to 0.40	%	ASTM D955
Across Flow : 24 hr	0.70 to 0.90	%	ASTM D955
Across Flow : 24 hr	0.77	%	ISO 294-4
Flow : 24 hr	0.33	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.50	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	14500	MPa	ASTM D638
--	13200	MPa	ISO 527-2/1
Tensile Strength			
Yield	234	MPa	ASTM D638
Yield	228	MPa	ISO 527-2
Break	234	MPa	ASTM D638
Break	228	MPa	ISO 527-2
Tensile Elongation			

Yield	2.3	%	ASTM D638
Yield	2.4	%	ISO 527-2
Break	2.3	%	ASTM D638
Break	2.4	%	ISO 527-2
Flexural Modulus			
--	12400	MPa	ASTM D790
--	13000	MPa	ISO 178
Flexural Strength			
--	338	MPa	ASTM D790
--	351	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	260	J/m	ASTM D256
23°C ²	24	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1400	J/m	ASTM D4812
23°C ³	93	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	14.6	J	ASTM D3763
--	7.60	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	256	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	255	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	254	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	259	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	4.9E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Transverse : -40 to 40°C	2.2E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	2.1E-5	cm/cm/°C	ISO 11359-2
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.	50 mm/min
2.	80*10*4
3.	80*10*4
4.	80*10*4 mm
5.	80*10*4 mm

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