

LNP™ LUBRICOMP™ RX05487 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP LUBRICOMP RX05487 is a compound based on Nylon 66 containing 10% Aramid Fiber, 10% Lubricant. Added features of this material are: Low Warpage, Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound RAL-4722 LW

Product reorder name: RX05487

General Information			
Filler / Reinforcement	Aramid Fiber,10% Filler by Weight		
Additive	Lubricant (10%)		
Features	Good Wear Resistance		
	Low Warpage		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	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	0.73	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.1	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3710	MPa	ASTM D638
--	3620	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	81.8	MPa	ASTM D638
Yield	79.8	MPa	ISO 527-2/5
Break ³	81.8	MPa	ASTM D638
Break	79.8	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	8.2	%	ASTM D638
Yield	8.9	%	ISO 527-2/5
Break ⁵	8.3	%	ASTM D638
Break	9.0	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	3270	MPa	ASTM D790

-- ⁷	3330	MPa	ISO 178
Flexural Stress	102	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.41		
vs. Itself - Static	0.36		
Wear Factor			ASTM D3702 Modified
Ring	0.325 to 0.350	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	17.5	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	45	J/m	ASTM D256
23°C ⁸	4.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	520	J/m	ASTM D4812
23°C ⁹	37	kJ/m ²	ISO 180/1U
Multi-Axial Instrumented Impact Energy	1.10	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	249	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	235	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	144	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	116	°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	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.	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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