

LNP™ LUBRICOMP™ RX99518 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP LUBRICOMP RX99518 is a compound based on PA66 containing Proprietary Fillers. Added feature of this material is: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound PDX-R-99518

Product reorder name: RX99518

General Information			
Filler / Reinforcement	Proprietary		
Features	Good Wear Resistance		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	1.0 to 3.0	%	
Across Flow : 24 hr	2.0 to 4.0	%	
Water Absorption			
24 hr, 50% RH	0.76	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3140	MPa	ASTM D638
--	3180	MPa	ISO 527-2/1
Tensile Stress			
Yield	71.0	MPa	ISO 527-2/5
Break ²	72.0	MPa	ASTM D638
Break	70.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ³	9.2	%	ASTM D638
Yield	9.2	%	ISO 527-2/5
Break ⁴	9.4	%	ASTM D638
Break	9.3	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁵	2880	MPa	ASTM D790
-- ⁶	2820	MPa	ISO 178
Flexural Stress	103	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.37		
vs. Itself - Static	0.35		
Wear Factor			ASTM D3702 Modified

Ring	2.00	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	15.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	50	J/m	ASTM D256
23°C ⁷	5.3	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	970	J/m	ASTM D4812
23°C ⁸	59	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	3.80	J	ASTM D3763
--	0.780	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	216	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	181	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	95.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	73.0	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	8.5E-6	cm/cm/°C	
Transverse : -30 to 30°C	9.2E-6	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	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.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	1.3 mm/min		
6.	2.0 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		

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