

LNP™ LUBRICOMP™ RX03643H compound

Polyamide 66
SABIC Innovative Plastics

Message:

LNP LUBRICOMP RX03643H is a compound based on Nylon 66 resin containing Proprietary Filler(s). Added features of this material include: Internally Lubricated.

Also known as: LNP* LUBRICOMP* Compound PDX-R-03643 HC

Product reorder name: RX03643H

General Information			
Filler / Reinforcement	Proprietary packing		
Additive	Lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.25	g/cm ³	ASTM D792
--	1.24	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 24 hours	1.0 - 1.2	%	ASTM D955
Transverse flow: 24 hours	0.70 - 0.90	%	ASTM D955
Vertical flow direction: 24 hours	0.79	%	ISO 294-4
Flow direction: 24 hours	1.1	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.90	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5520	MPa	ASTM D638
--	5310	MPa	ISO 527-2/1
Tensile Strength			
Yield	96.5	MPa	ASTM D638
Yield	95.0	MPa	ISO 527-2
Fracture	96.5	MPa	ASTM D638
Fracture	95.0	MPa	ISO 527-2
Tensile Elongation			
Yield	2.4	%	ASTM D638
Yield	2.3	%	ISO 527-2
Fracture	2.4	%	ASTM D638
Fracture	2.3	%	ISO 527-2
Flexural Modulus			
--	4830	MPa	ASTM D790
--	4500	MPa	ISO 178

Flexural Stress	149	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
With self-dynamics	0.46		ASTM D3702 Modified
With Self-Static	0.37		ASTM D3702 Modified
Wear Factor - Washer	159	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	32	J/m	ASTM D256
23°C ²	3.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	420	J/m	ASTM D4812
23°C ³	28	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	6.90	J	ASTM D3763
--	2.20	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	256	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁴	252	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	239	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	221	°C	ISO 75-2/af
Linear thermal expansion coefficient			
Flow: -40 to 40°C	4.3E-5	cm/cm/°C	ASTM E831
Flow: -40 to 40°C	4.2E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	7.4E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.5E-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 - 0.25	%	
Rear Temperature	266 - 277	°C	
Middle Temperature	282 - 293	°C	
Front Temperature	293 - 304	°C	
Processing (Melt) Temp	277 - 288	°C	
Mold Temperature	82.2 - 93.3	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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