

LNP™ LUBRICOMP™ RFN14 compound

Polyamide 66

SABIC Innovative Plastics

Message:

LNP LUBRICOMP RFN14 is a compound based on Nylon 66 containing 20% Glass Fiber, 5% MOS2. Added features of this grade include: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound RFL-4214

Product reorder name: RFN14

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Molybdenum Disulfide Lubricant (5%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.33	g/cm ³	
--	1.32	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.60	%	
Across Flow : 24 hr	0.80 to 2.0	%	
Water Absorption			
24 hr, 50% RH	0.67	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.96	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8860	MPa	ASTM D638
--	8530	MPa	ISO 527-2/1
Tensile Strength			
Break ²	135	MPa	ASTM D638
Break	134	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.9	%	ASTM D638
Break	1.9	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	7450	MPa	ASTM D790
-- ⁵	7270	MPa	ISO 178
Flexural Stress			
--	204	MPa	ISO 178
Break, 50.0 mm Span ⁶	205	MPa	ASTM D790

Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.41		
vs. Itself - Static	0.45		
Wear Factor			ASTM D3702 Modified
Ring	1.15	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	104	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	48	J/m	ASTM D256
23°C ⁷	5.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	400	J/m	ASTM D4812
23°C ⁸	32	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	5.90	J	ASTM D3763
--	1.70	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	260	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	258	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	249	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	245	°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.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		

9.	80*10*4 mm
10.	80*10*4 mm

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