

LNP™ LUBRICOMP™ RFL369 compound

Polyamide 66

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP RFL369 is a compound based on PA 66 resin containing Glass Fiber, PTFE, Flame Retardant. Added features include: Flame Retardant, internally lubricated

Also known as: LNP* LUBRICOMP* Compound RFL-4036 FR

Product reorder name: RFL369

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	Flame Retardant		
	PTFE Lubricant		
Features	Flame Retardant		
	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.74	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.20 to 0.40	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11500	MPa	ISO 527-2/1
Tensile Stress (Yield)	128	MPa	ISO 527-2/5
Tensile Strain (Break)	1.7	%	ISO 527-2/5
Flexural Modulus ¹	8500	MPa	ISO 178
Flexural Stress	152	MPa	ISO 178
Flexural Strain at Break ²	2.5	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	20	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 64.0 mm Span	253	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	225	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	4.2E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.8E-5	cm/cm/°C	
Flammability	Nominal Value	Test Method	
Flame Rating (3.00 mm, Testing by SABIC)	V-0	UL 94	

Injection	Nominal Value	Unit
Drying Temperature	121	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.020	%
Rear Temperature	293 to 304	°C
Middle Temperature	310 to 321	°C
Front Temperature	321 to 332	°C
Processing (Melt) Temp	304 to 327	°C
Mold Temperature	82.2 to 110	°C
Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | 2 mm/min |
| 3. | 80*10*4 |
| 4. | 80*10*4 |
| 5. | 80*10*4 mm |

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