

**Product Texts**

LNP LUBRILOY RF208 compound is based on Nylon 6/6 resin containing 40% glass fiber and proprietary lubricant. Added features of this grade include: Wear Resistant.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.4	%	ISO 294-4, 2577
Molding shrinkage, normal	1.1	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.4	mm/mm	ASTM D 955
Mold Shrinkage, TD	1.1	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	10500	MPa	ISO 527
Stress at break	136	MPa	ISO 527
Strain at break	2.7	%	ISO 527
Flexural modulus	11300	MPa	ISO 178
Flexural strength	211	MPa	ISO 178
Izod impact strength, +23°C, 4mm	55	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	13	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	12340	MPa	ASTM D 638
Tensile Strength at Break	139	MPa	ASTM D 638
Elongation at Break	2.5	%	ASTM D 638
Flexural Modulus	9030	MPa	ASTM D 790
Flexural Strength	200	MPa	ASTM D 790
Izod Impact notched, 1/8 in	133	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	720	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	238	°C	ISO 75-1/-2
<b>ASTM Data</b>			
DTUL @ 264 psi	241	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Humidity absorption	0.4	%	Sim. to ISO 62
Density	1340	kg/m <sup>3</sup>	ISO 1183
Water Absorption, 24hr	0.27	%	ASTM D 570
Density	1340	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.25	%	-
Melt temperature	270 - 280	°C	-
Mold temperature	80 - 95	°C	-
Zone 1	265 - 275	°C	-
Zone 2	280 - 295	°C	-
Zone 3	295 - 305	°C	-
Screw speed	30 - 60	rpm	-
Back pressure	0.2 - 0.3	MPa	-

**Characteristics**

**Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific