

**Product Texts**

LNP LUBRICOMP RFN18S compound is based on Nylon 6/6 resin containing 49% glass fiber, Molybdenum diSulfide (MoS<sub>2</sub>). Added features of this grade include: Heat Stabilized, Wear Resistant.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	1.2	%	ISO 294-4, 2577
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.3	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	14000	MPa	ISO 527
Stress at break	192	MPa	ISO 527
Strain at break	2.2	%	ISO 527
Flexural modulus	13100	MPa	ISO 178
Flexural strength	287	MPa	ISO 178
Izod impact strength, +23°C, 4mm	59	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C, 4mm	10	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	15510	MPa	ASTM D 638
Tensile Strength at Break	177	MPa	ASTM D 638
Elongation at Break	1.8	%	ASTM D 638
Flexural Modulus	10750	MPa	ASTM D 790
Flexural Strength	268	MPa	ASTM D 790
Izod Impact notched, 1/8 in	84	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	891	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	240	°C	ISO 75-1/-2
<b>ASTM Data</b>			
DTUL @ 66 psi	259	°C	ASTM D 648
DTUL @ 264 psi	250	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Humidity absorption	1	%	Sim. to ISO 62
Density	1510	kg/m <sup>3</sup>	ISO 1183
Water Absorption, 24hr	0.61	%	ASTM D 570
Density	1510	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	280 - 305	°C	-
Mold temperature	95 - 110	°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