

**Product Texts**

LNP™ LUBRICOMP™ RX18020 is a compound based on PA 66 resin containing Glass Fiber, Proprietary Lubricant. Added features include; Internally Lubricated.

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt volume-flow rate, MVR	69	cm <sup>3</sup> /10min	ISO 1133
Temperature	300	°C	-
Load	1.2	kg	-
<b>ASTM Data</b>			
Mold Shrinkage, MD	0.006	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.012	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Tensile Modulus	6100	MPa	ISO 527
Stress at break	121	MPa	ISO 527
Strain at break	4	%	ISO 527
Flexural modulus, 23°C	4800	MPa	ISO 178
Flexural strength	174	MPa	ISO 178
Charpy impact strength, +23°C	65	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	53	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 180/1A
<b>ASTM Data</b>			
Tensile Modulus	6200	MPa	ASTM D 638
Tensile Strength at Break	118	MPa	ASTM D 638
Elongation at Break	4	%	ASTM D 638
Flexural Modulus	4600	MPa	ASTM D 790
Flexural Strength	160	MPa	ASTM D 790
Izod Impact notched, 1/8 in	60	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	757	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Temp. of deflection under load, 1.80 MPa	231	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	255	°C	ISO 75-1/-2
Vicat softening temperature, B	244	°C	ISO 306
Coeff. of linear therm. expansion, parallel	38	E-6/K	ISO 11359-1/-2
Coeff. of linear therm. expansion, normal	96	E-6/K	ISO 11359-1/-2
Glow Wire Flammability Index (GWFI)	675	°C	IEC 60695-2-12
GWFI - thickness tested (1)	0.8	mm	-
Glow Wire Flammability Index (GWFI)	675	°C	IEC 60695-2-12
GWFI - thickness tested (2)	1	mm	-
Glow Wire Flammability Index (GWFI)	675	°C	IEC 60695-2-12
GWFI - thickness tested (3)	1.5	mm	-
Glow Wire Ignition Temperature (GWIT)	700	°C	IEC 60695-2-13
GWIT - thickness tested (1)	0.8	mm	-
Glow Wire Ignition Temperature (GWIT)	700	°C	IEC 60695-2-13
GWIT - thickness tested (2)	1	mm	-
Glow Wire Ignition Temperature (GWIT)	700	°C	IEC 60695-2-13
GWIT - thickness tested (3)	1.5	mm	-
<b>ASTM Data</b>			
DTUL @ 66 psi	257	°C	ASTM D 648
DTUL @ 264 psi	247	°C	ASTM D 648

Other properties	Value	Unit	Test Standard
Humidity absorption	0.4	%	Sim. to ISO 62
Density	1210	kg/m <sup>3</sup>	ISO 1183

**LNP™ LUBRICOMP™ Compound RX18020 - Europe**

PA66-GF

Saudi Basic Industries Corporation (SABIC)

Water Absorption, 24hr	<b>0.2</b>	%	ASTM D 570
Density	<b>1210</b>	kg/m <sup>3</sup>	ASTM D 792

<b>Film Properties</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>Other Standards<sup>[S]</sup></b>			
Dynamic coefficient of friction	<b>0.34</b>	-	ASTM D3702

S: These properties are reported by the producer according standards that are different to our defaults.

<b>Processing Recommendation Injection Molding</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
Pre-drying - Temperature	<b>95 - 100</b>	°C	-
Pre-drying - Time	<b>6 - 8</b>	h	-
Melt temperature	<b>250 - 280</b>	°C	-
Mold temperature	<b>60 - 90</b>	°C	-
Zone 1	<b>240 - 260</b>	°C	-
Zone 2	<b>250 - 270</b>	°C	-
Zone 3	<b>260 - 280</b>	°C	-
Nozzle temperature	<b>255 - 275</b>	°C	-
Screw speed	<b>60 - 100</b>	rpm	-
Back pressure	<b>0.3 - 0.7</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

Europe

**Additives**

Lubricants