



LNP™ LUBRICOMP™ Compound RFL33

Americas: COMMERCIAL

Also known as: LNP™ LUBRICOMP™ Compound RFL-4033

Product reorder name: RFL33

LNP LUBRICOMP RFL33 is a compound based on Nylon 66 resin containing 15% Glass Fiber, 15% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yield	1220	kgf/cm ²	ASTM D 638
Tensile Stress, break	1220	kgf/cm ²	ASTM D 638
Tensile Strain, yield	3.1	%	ASTM D 638
Tensile Strain, break	3.1	%	ASTM D 638
Tensile Modulus, 50 mm/min	70300	kgf/cm ²	ASTM D 638
Flexural Stress	1820	kgf/cm ²	ASTM D 790
Flexural Modulus	56200	kgf/cm ²	ASTM D 790
Tensile Stress, yield	118	MPa	ISO 527
Tensile Stress, break	118	MPa	ISO 527
Tensile Strain, yield	3	%	ISO 527
Tensile Strain, break	3	%	ISO 527
Tensile Modulus, 1 mm/min	6440	MPa	ISO 527
Flexural Stress	183	MPa	ISO 178
Flexural Modulus	5800	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	58	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	77	cm-kgf	ASTM D 3763
Multiaxial Impact	21	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	35	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	261	°C	ASTM D 648



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THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	247	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.28E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	3.96E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	3.9E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	260	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	243	°C	ISO 75/Af
PHYSICAL			
Density	1.37	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.6	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.5 - 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1.6 - 1.8	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.64	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	1.7	%	ISO 294
Wear Factor Washer	19	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.39	-	ASTM D 3702 Modified
Static COF	0.45	-	ASTM D 3702 Modified
Density	1.36	g/cm ³	ISO 1183



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	280 - 305	°C
Front - Zone 3 Temperature	295 - 305	°C
Middle - Zone 2 Temperature	280 - 295	°C
Rear - Zone 1 Temperature	265 - 275	°C
Mold Temperature	95 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm