LNP™ LUBRILOY™ COMPOUND UX99725

PDX-U-99725

DESCRIPTION

LNP LUBRILOY* UX99725 is a compound based on Polyphthalamide resin containing Proprietary Lubricant. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	63	MPa	ISO 527
Tensile Stress, yield, 5 mm/min	70	MPa	ISO 527
Tensile Stress, break, 5 mm/min	57	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6.5	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	93	MPa	ISO 178
Flexural Modulus	2360	MPa	ISO 178
Flexural Modulus, 2 mm/min	2100	MPa	ISO 178
IMPACT			
Izod Impact, notched 80*10*4 +23°C	11	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, xflow	8.4E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	147	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	129	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	1.4	%	SABIC method
Mold Shrinkage, flow, 24 hrs	1.9	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	1.5	%	ISO 294
Density	1.11	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	0.46	%	ISO 62-1
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.15	%	
Melt Temperature	315 – 330	°C	
Front - Zone 3 Temperature	325 – 340	°C	
Middle - Zone 2 Temperature	315 – 325	°C	
Rear - Zone 1 Temperature	310 – 320	°C	
Mold Temperature	150 – 170	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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