LNP™ LUBRICOMP™ COMPOUND ECL36XXQ

ECL36XXQ

DESCRIPTION

LNP* LUBRICOMP* ECL36XXQ is a compound based on Polyetherimide containing 30% Carbon Fiber, 15% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	222	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	0.9	%	ASTM D 638
Tensile Modulus, 5 mm/min	32860	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	324	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26300	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	226	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1	%	ISO 527
Tensile Modulus, 1 mm/min	30420	MPa	ISO 527
IMPACT			
Izod Impact, unnotched, 23°C	413	J/m	ASTM D 4812
Izod Impact, notched, 23°C	69	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	11	J	ASTM D 3763
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	208	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.39	-	ASTM D 792
Density	1.39	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.01 – 0.05	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.1 – 0.4	%	ASTM D 955
Poisson's Ratio	0.43	-	ASTM E 132
Wear Factor Washer	22	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.39	-	ASTM D 3702 Modified: Manual
Static COF	0.42	-	ASTM D 3702 Modified: Manual
ELECTRICAL			
Surface Resistivity	1.E+02 – 1.E+04	Ohm	ASTM D 257
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4 – 6	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	360 – 365	°C	
Front - Zone 3 Temperature	365 – 375	°C	
Middle - Zone 2 Temperature	355 – 365	°C	
Rear - Zone 1 Temperature	345 – 355	°C	
Mold Temperature	120 – 150	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	60 – 100	rpm	

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