LNP™ LUBRICOMP™ COMPOUND IFL36R

DESCRIPTION

Internally lubricated PA6.12, containing Glass Fiber and PTFE

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	148	MPa	ISO 527
Tensile Stress, break, 5 mm/min	147	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.3	%	ISO 527
Tensile Strain, break, 5 mm/min	3.4	%	ISO 527
Tensile Modulus, 1 mm/min	8700	MPa	ISO 527
Flexural Stress, yield, 2 mm/min	200	MPa	ISO 178
Flexural Stress, break, 2 mm/min	198	MPa	ISO 178
Flexural Modulus, 2 mm/min	7300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	70	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	12	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	2.8E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.01E-04	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	197	°C	ISO 75/Af
PHYSICAL			
Wear Factor Washer	9	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.55	-	ASTM D 3702 Modified: Manual
Static COF	0.5	-	ASTM D 3702 Modified: Manual
Density	1.42	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.12 – 0.2	%	
Melt Temperature	270 – 275	°C	
Front - Zone 3 Temperature	270 – 280	°C	
Middle - Zone 2 Temperature	260 – 270	°C	
Rear - Zone 1 Temperature	255 – 265	°C	
Mold Temperature	65 – 95	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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