LNP™ LUBRICOMP™ COMPOUND KA000

KAF

DESCRIPTION

LNP LUBRICOMP KA000 is a compound based on Acetal Copolymer resin containing Aramid Fiber, Proprietary Lubricant.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	60	MPa	ISO 527
Tensile Strain, break, 5 mm/min	8.8	%	ISO 527
Flexural Stress, break, 2 mm/min	64	MPa	ISO 178
Flexural Modulus, 2 mm/min	2500	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	45	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m²	ISO 180/1A
THERMAL			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	135	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage on Tensile Bar, flow	1.4 – 2.2	%	SABIC method
Wear Factor Washer	8	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.23	-	ASTM D 3702 Modified: Manual
Static COF	0.21	-	ASTM D 3702 Modified: Manual
Density	1.37	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	
Melt Temperature	200 – 215	°C	
Front - Zone 3 Temperature	210 – 220	°C	
Middle - Zone 2 Temperature	195 – 205	°C	
Rear - Zone 1 Temperature	175 – 190	°C	
Mold Temperature	80 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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