LNP™ LUBRICOMP™ COMPOUND KFL25

KFL-4025

DESCRIPTION

LNP LUBRICOMP* KFL25 is a compound based on Acetal Copolymer resin containing 25% Glass Fiber, 10% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	85	MPa	ASTM D 638
Tensile Strain, break	1.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	10240	MPa	ASTM D 638
Flexural Stress	131	MPa	ASTM D 790
Flexural Modulus	9100	MPa	ASTM D 790
Tensile Stress, break	84	MPa	ISO 527
Tensile Strain, break	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	9870	MPa	ISO 527
Flexural Stress	130	MPa	ISO 178
Flexural Modulus	9200	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	293	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	8	J	ASTM D 3763
Multiaxial Impact	1	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	18	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	165	°C	ASTM D 648
CTE, -40°C to 40°C, flow	8.22E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.33E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	8.26E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.32E-05	1/°C	ISO 11359-2
PHYSICAL			
Density	1.65	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.19	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.5	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.96	%	ISO 294
Density	1.65	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	
Drying Time	4	hrs	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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