LNP™ LUBRICOMP™ COMPOUND KFL36

KFL-4036
REGION ASIA

DESCRIPTION

LNP LUBRICOMP KFL36 is a compound based on Acetal Copolymer resin containing 30% Glass Fiber, 15% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20181219

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	88	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	10820	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	107	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	9280	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	84	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	10610	MPa	ISO 527
Flexural Stress	130	MPa	ISO 178
Flexural Modulus, 2 mm/min	9930	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	50	J/m	ASTM D 256
Multiaxial Impact	2	J	ISO 6603
Instrumented Impact Total Energy, 23°C	10	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	183	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	161	°C	ASTM D 648
CTE, -30°C to 30°C, flow	9.51E+01	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	6.48E+01	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	163	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	161	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.75	-	ASTM D 792
Density	1.75	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.16	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.7 – 1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Wear Factor Washer	234	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.4	-	ASTM D 3702 Modified: Manual
Static COF	0.46	-	ASTM D 3702 Modified: Manual
Moisture Absorption (23°C / 50% RH)	0.26	%	ISO 62

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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