LNP™ LUBRICOMP™ COMPOUND KI001XXJ

KL-4410 HC

DESCRIPTION

LNP LUBRICOMP KI001XXJ is a compound based on Acetal containing 2% Silicone. Added features of this grade include: Wear Resistant, Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	55	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	52	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	16	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	46	%	ASTM D 638
Tensile Modulus, 50 mm/min	2750	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	74	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2280	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	1550	J/m	ASTM D 4812
Izod Impact, notched, 23°C	81	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	106	°C	ASTM D 648
PHYSICAL			
Moisture Absorption, 50% RH, 24 hrs	0.24	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	2.4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	2.4	%	ASTM D 955
Wear Factor Washer	22	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.44	-	ASTM D 3702 Modified: Manual
Static COF	0.34	-	ASTM D 3702 Modified: Manual
Density	1.4	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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