LNP™ LUBRICOMP™ COMPOUND KP004AH

KL-4540 D HC

DESCRIPTION

LNP LUBRICOMP KP004AH is a compound based on Acetal Homopolymer resin containing 20% PTFE/Silicone. Added features of this material include: Wear Resistant

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	50	MPa	ASTM D 638
Tensile Strain, break	12.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	2200	MPa	ASTM D 638
Flexural Stress	75	MPa	ASTM D 790
Flexural Modulus	2410	MPa	ASTM D 790
Tensile Stress, break	45	MPa	ISO 527
Tensile Strain, break	10.5	%	ISO 527
Tensile Modulus, 1 mm/min	2600	MPa	ISO 527
Flexural Stress	77	MPa	ISO 178
Flexural Modulus	2800	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	427	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	5	J	ASTM D 3763
Multiaxial Impact	1	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	29	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	163	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	99	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	99	°C	ISO 75/Af
PHYSICAL			
Density	1.49	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.2	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	2.1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	2.1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	2.14	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	2.05	%	ISO 294
Wear Factor Washer	9	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.25	-	ASTM D 3702 Modified: Manual
Static COF	0.16	-	ASTM D 3702 Modified: Manual
Density	1.49	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	80	°C	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
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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