LNP™ LUBRICOMP™ COMPOUND WFL28

DESCRIPTION

LNP LUBRICOMP WFL28 is a compound based on Polybutylene Terephalate resin containing Glass Fiber, PTFE. Added features include: Internally Lubricated.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	126	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.3	%	ISO 527
Flexural Stress, yield, 2 mm/min	187	MPa	ISO 178
Flexural Modulus, 2 mm/min	10800	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	10	kJ/m²	ISO 180/1A
PHYSICAL			
Density	1.7	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.05	%	
Melt Temperature	240 – 265	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	245 – 255	°C	
Rear - Zone 1 Temperature	220 – 230	°C	
Mold Temperature	80 – 100	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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