LNP™ LUBRICOMP™ COMPOUND XFL21R

XFL-4021 MR

DESCRIPTION

LNP LUBRICOMP XFL21R is a compound based on Amorphous Nylon resin containing 5% Glass Fiber, 10% PTFE. Added features of this material include: Wear Resistant, Mold Release.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	84	MPa	ASTM D 638
Tensile Strain, break	4.1	%	ASTM D 638
Tensile Modulus, 50 mm/min	3730	MPa	ASTM D 638
Flexural Stress	131	MPa	ASTM D 790
Flexural Modulus	3900	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	506	J/m	ASTM D 4812
Izod Impact, notched, 23°C	58	J/m	ASTM D 256
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
PHYSICAL			
Density	1.21	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.7	%	ASTM D 955
INJECTION MOLDING			
Drying Temperature	100 – 120	°C	
Drying Time	6 – 12	hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	260 – 300	°C	
Front - Zone 3 Temperature	290 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 270	°C	
Mold Temperature	50 – 100	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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