LNP™ LUBRICOMP™ KFL36 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

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.
Also known as: LNP* LUBRICOMP* Compound KFL-4036
Product reorder name: KFL36

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	PTFE Lubricant (15%)		
Features	Good Wear Resistance Lubricated		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.75	g/cm³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.70 to 1.0	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.16	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.26	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	10800	MPa	ASTM D638
--	10600	MPa	ISO 527-2/1
Tensile Strength			
Break [2]	88.0	MPa	ASTM D638
Break	84.0	MPa	ISO 527-2/5
Tensile Elongation			
Break [3]	1.3	%	ASTM D638
Break	1.3	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span [4]	9280	MPa	ASTM D790
-- [5]	9930	MPa	ISO 178
Flexural Stress			
--	130	MPa	ISO 178
Break, 50.0 mm Span [6]	107	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified

vs. Itself - Dynamic	0.40		
vs. Itself - Static	0.46		
Wear Factor - Washer	235	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	50	J/m	ASTM D256
23°C [7]	5.9	kJ/m²	ISO 180/1A
Unnotched Izod Impact Strength [8] (23°C)	25	kJ/m²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.3	J	ASTM D3763
--	2.50	J	ISO 6603-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	183	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span [9]	163	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	161	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span [10]	161	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	9.5E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.5E-5	cm/cm/°C	
Injection	**Nominal Value**	**Unit**	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	177 to 188	°C	
Middle Temperature	193 to 204	°C	
Front Temperature	210 to 221	°C	
Processing (Melt) Temp	199 to 216	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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