

LNP™ LUBRICOMP™ KFI12 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP LUBRICOMP* KFI12 is a compound based on Acetal Copolymer resin containing 10% Glass Fiber, 2% Silicone. Added feature of this grade is: Wear Resistant.
Also known as: LNP* LUBRICOMP* Compound KFL-4412
Product reorder name: KFI12

General Information			
Filler / Reinforcement	Glass Fiber,10% Filler by Weight		
Additive	Silicone Lubricant (2%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.44	g/cm ³	ASTM D792
Water Absorption			
24 hr, 50% RH	0.25	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.34	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	4920	MPa	ASTM D638
--	4790	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	62.0	MPa	ASTM D638
Yield	62.0	MPa	ISO 527-2/5
Break ³	56.0	MPa	ASTM D638
Break	58.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	2.3	%	ASTM D638
Yield	2.3	%	ISO 527-2/5
Break ⁵	3.3	%	ASTM D638
Break	2.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4070	MPa	ASTM D790
-- ⁷	4150	MPa	ISO 178
Flexural Stress			
--	91.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	91.0	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	54	J/m	ASTM D256
23°C ⁹	5.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	420	J/m	ASTM D4812
23°C ¹⁰	26	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	5.60	J	ASTM D3763
--	2.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	163	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	162	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	161	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	159	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	8.3E-5	cm/cm/°C	
Transverse : -30 to 30°C	9.0E-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.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	80*10*4		
10.	80*10*3		
11.	80*10*4 mm		
12.	80*10*4 mm		

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