

LNP™ LUBRICOMP™ KL004L compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP LUBRICOMP KL004L is a compound based on Acetal Copolymer resin containing 20% PTFE. Added features of this material include: Wear Resistant, Low Extractible.
Also known as: LNP* LUBRICOMP* Compound FULTON 404 LE
Product reorder name: KL004L

General Information			
Additive	PTFE Lubricant (20%)		
Features	Good Wear Resistance		
	Low Extractables		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.52	g/cm ³	ASTM D792
--	1.51	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955, ISO 294-4
Flow : 24 hr	2.0 to 2.5	%	
Across Flow : 24 hr	2.0 to 2.5	%	
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2760	MPa	ASTM D638
--	2340	MPa	ISO 527-2/1
Tensile Strength			
Yield	47.6	MPa	ASTM D638
Yield	48.0	MPa	ISO 527-2
Break	46.9	MPa	ASTM D638
Break	47.0	MPa	ISO 527-2
Tensile Elongation			
Yield	11	%	ASTM D638, ISO 527-2
Break	22	%	ASTM D638
Break	20	%	ISO 527-2
Flexural Modulus			
--	2070	MPa	ASTM D790
--	2100	MPa	ISO 178
Flexural Stress	59.0	MPa	ISO 178

Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.25		
vs. Itself - Static	0.14		
Wear Factor - Washer	10.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	43	J/m	ASTM D256
23°C ²	5.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	670	J/m	ASTM D4812
23°C ³	39	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	4.70	J	ASTM D3763
--	1.40	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	154	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	146	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	84.4	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	83.0	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	1.2E-4	cm/cm/°C	
Transverse : -40 to 40°C	1.2E-4	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.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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