

LNP™ LUBRICOMP™ KAL22 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP KAL22 is a compound based on Acetal Copolymer resin containing 10% PTFE, 10% Aramid Fiber. Added feature of this material is: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound KAL-4022

Product reorder name: KAL22

General Information			
Filler / Reinforcement	Aramid fiber, 10% filler by weight		
Additive	PTFE lubricant (10%)		
Features	Good wear resistance		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.46	g/cm ³	ASTM D792
--	1.45	g/cm ³	ISO 1183
Molding Shrinkage			
Flow ¹	1.8 - 2.2	%	Internal method
Flow: 24 hours	2.0 - 4.0	%	ASTM D955
Transverse flow: 24 hours	2.0 - 4.0	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ²	3640	MPa	ASTM D638
--	3460	MPa	ISO 527-2/1
Tensile Stress			
Yield	57.0	MPa	ISO 527-2/5
Fracture ³	58.0	MPa	ASTM D638
Fracture	56.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	6.5	%	ASTM D638
Yield	6.3	%	ISO 527-2/5
Fracture ⁵	7.4	%	ASTM D638
Fracture	7.4	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁶	3090	MPa	ASTM D790
-- ⁷	3080	MPa	ISO 178
Flexural Stress	77.0	MPa	ISO 178

Coefficient of Friction		ASTM D3702 Modified	
With self-dynamics	0.23	ASTM D3702 Modified	
With Self-Static	0.16	ASTM D3702 Modified	
Wear Factor		ASTM D3702 Modified	
Ring	0.00	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Washer	8.00	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	54	J/m	ASTM D256
23°C ⁸	5.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	510	J/m	ASTM D4812
23°C ⁹	32	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	162	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	132	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁰	87.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	177 - 188	°C	
Middle Temperature	193 - 204	°C	
Front Temperature	210 - 221	°C	
Processing (Melt) Temp	199 - 216	°C	
Mold Temperature	82.2 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	Tensile Bar		
2.	5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	Type 1, 5.0 mm/min		
5.	Type 1, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		

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