

LNP™ LUBRICOMP™ QCL349 compound

Polyamide 610

SABIC Innovative Plastics

Message:

LNP LUBRICOMP QCL349 is a compound based on Nylon 6/10 resin containing 15% PTFE, 20% Carbon Fiber. Added features of this material include:

Wear Resistant, Flame Retardant, Electrically Conductive.

Also known as: LNP* LUBRICOMP* Compound QCL-4034 FR-1

Product reorder name: QCL349

General Information			
UL YellowCard	E121562-101343442		
Filler / Reinforcement	Carbon Fiber,20% Filler by Weight		
Additive	PTFE Lubricant (15%)		
Features	Electrically Conductive		
	Flame Retardant		
	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.52	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.10	%	ASTM D955
Across Flow : 24 hr	0.80	%	ASTM D955
Across Flow : 24 hr	0.78	%	ISO 294-4
Flow : 24 hr	0.11	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	16500	MPa	ASTM D638
--	15800	MPa	ISO 527-2/1
Tensile Strength			
Yield	169	MPa	ASTM D638
Yield	162	MPa	ISO 527-2
Break	159	MPa	ASTM D638
Break	162	MPa	ISO 527-2
Tensile Elongation			
Yield	1.8	%	ASTM D638
Yield	1.7	%	ISO 527-2
Break	1.9	%	ASTM D638
Break	1.7	%	ISO 527-2

Flexural Modulus			
--	13100	MPa	ASTM D790
--	13000	MPa	ISO 178
Flexural Strength			
--	241	MPa	ASTM D790
--	239	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.34		
vs. Itself - Static	0.28		
Wear Factor - Washer	444	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	53	J/m	ASTM D256
23°C ²	5.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	530	J/m	ASTM D4812
23°C ³	33	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	4.20	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	218	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	218	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	200	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	198	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	5.6E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	5.7E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	2.0E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	1.9E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 to 0.20	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	260 to 271	°C	
Front Temperature	271 to 282	°C	
Processing (Melt) Temp	271 to 277	°C	
Mold Temperature	82.2 to 93.3	°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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