

LNP™ LUBRICOMP™ QCL34 compound

Polyamide 610

SABIC Innovative Plastics

Message:

LNP LUBRICOMP QCL34 is a compound based on Nylon 6/10 resin containing 15% PTFE, 20% Carbon Fiber. Added features of this material include: Wear Resistant, Electrically Conductive.

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

Product reorder name: QCL34

General Information			
Filler / Reinforcement	Carbon Fiber,20% Filler by Weight		
Additive	PTFE Lubricant (15%)		
Features	Electrically Conductive		
	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.27	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.060 to 0.080	%	
Across Flow : 24 hr	0.40 to 0.60	%	
Water Absorption			
24 hr, 50% RH	0.19	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.30	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	16600	MPa	ASTM D638
--	15600	MPa	ISO 527-2/1
Tensile Strength			
Break ²	201	MPa	ASTM D638
Break	197	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.7	%	ASTM D638
Break	2.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	12400	MPa	ASTM D790
-- ⁵	12500	MPa	ISO 178
Flexural Stress			
--	280	MPa	ISO 178
Yield, 50.0 mm Span ⁶	289	MPa	ASTM D790

Break, 50.0 mm Span ⁷	288	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.39		
vs. Itself - Static	0.33		
Wear Factor			ASTM D3702 Modified
Ring	0.300	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	26.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	110	J/m	ASTM D256
23°C ⁸	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	840	J/m	ASTM D4812
23°C ⁹	53	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.0	J	ASTM D3763
--	3.58	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	221	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	212	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	206	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	2.1E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.8E-5	cm/cm/°C	
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.	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.	1.3 mm/min
8.	80*10*4
9.	80*10*3
10.	80*10*4 mm
11.	80*10*4 mm

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