

LNP™ LUBRICOMP™ KAL22M compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP LUBRICOMP* KAL22M is a compound based on Acetal Copolymer resin containing 10% PTFE, 10% Aramid. Added features of this material include: Wear Resistant.

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

Product reorder name: KAL22M

General Information			
Filler / Reinforcement	Aramid Fiber,10% Filler by Weight		
Additive	PTFE Lubricant (10%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.40	g/cm ³	
--	1.45	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	2.0 to 4.0	%	
Across Flow : 24 hr	2.0 to 4.0	%	
Water Absorption			
24 hr, 50% RH	0.21	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.35	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2870	MPa	ASTM D638
--	2590	MPa	ISO 527-2/1
Tensile Strength			
Break ²	41.0	MPa	ASTM D638
Break	39.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ³	8.5	%	ASTM D638
Yield	8.8	%	ISO 527-2/5
Break ⁴	14	%	ASTM D638
Break	14	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁵	2430	MPa	ASTM D790
-- ⁶	2420	MPa	ISO 178

Flexural Stress	62.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.23		
vs. Itself - Static	0.16		
Wear Factor - 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	36	J/m	ASTM D256
23°C ⁷	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	370	J/m	ASTM D4812
23°C ⁸	26	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	5.00	J	ASTM D3763
--	1.00	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	155	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	147	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	94.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	84.0	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	9.9E-5	cm/cm/°C	
Transverse : -30 to 30°C	1.0E-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.	5.0 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		
5.	1.3 mm/min		
6.	2.0 mm/min		
7.	80*10*4		

8.	80*10*4
9.	80*10*4 mm
10.	80*10*4 mm

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