

LNP™ LUBRICOMP™ Cypoloy_C6303

compound

Polycarbonate + ABS

SABIC Innovative Plastics

Message:

LNP LUBRICOMP CYCOLOY_C6303 compound is a Wear resistant (5% PTFE), flame retardant PC+ABS. High heat and good hydrolytic stability. UL listing from Japan and Pacific.

General Information			
Additive	PTFE Lubricant (5%)		
Features	Flame Retardant		
	Good Wear Resistance		
	High Heat Resistance		
	Hydrolytically Stable		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.25	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR)			ASTM D1238
260°C/2.16 kg	10	g/10 min	
260°C/5.0 kg	50	g/10 min	
Molding Shrinkage - Flow (3.20 mm)	0.40 to 0.60	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2690	MPa	ASTM D638
--	2870	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	65.5	MPa	ASTM D638
Yield	100	MPa	ISO 527-2/5
Yield	65.0	MPa	ISO 527-2/50
Break ³	51.0	MPa	ASTM D638
Break	50.0	MPa	ISO 527-2/50
Tensile Elongation			
Yield ⁴	4.5	%	ASTM D638
Yield	6.0	%	ISO 527-2/5
Yield	4.6	%	ISO 527-2/50
Break ⁵	30	%	ASTM D638
Break	22	%	ISO 527-2/50

Flexural Modulus			
50.0 mm Span ⁶	2760	MPa	ASTM D790
-- ⁷	2600	MPa	ISO 178
Flexural Strength ⁸ (Yield, 50.0 mm Span)	106	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	96	J/m	ASTM D256
23°C ⁹	7.4	kJ/m ²	ISO 180/1A
Instrumented Dart Impact (23°C, Total Energy)	48.6	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	109	°C	
1.8 MPa, Unannealed, 3.20 mm	92.8	°C	
1.8 MPa, Unannealed, 6.40 mm	102	°C	
Vicat Softening Temperature			
--	118	°C	ASTM D1525 ¹⁰
--	117	°C	ISO 306/B120
CLTE			
Flow : -40 to 40°C	6.3E-5	cm/cm/°C	ASTM E831
Flow : 23 to 80°C	6.5E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	6.3E-5	cm/cm/°C	ASTM E831
Transverse : 23 to 80°C	6.8E-5	cm/cm/°C	ISO 11359-2
RTI Elec	60.0	°C	UL 746
RTI Imp	60.0	°C	UL 746
RTI Str	60.0	°C	UL 746
Electrical	Nominal Value		Test Method
High Amp Arc Ignition (HAI)	PLC 1		UL 746
Hot-wire Ignition (HWI)	PLC 3		UL 746
Flammability	Nominal Value		Test Method
Flame Rating			UL 94
1.19 mm	V-1		
1.50 mm	V-0		
2.49 mm	5VB		
Injection	Nominal Value	Unit	
Drying Temperature	82.2 to 87.8	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	8.0	hr	
Suggested Max Moisture	0.040	%	
Suggested Shot Size	30 to 80	%	
Rear Temperature	221 to 254	°C	
Middle Temperature	221 to 266	°C	

Front Temperature	243 to 277	°C
Nozzle Temperature	243 to 277	°C
Processing (Melt) Temp	243 to 277	°C
Mold Temperature	60.0 to 82.2	°C
Back Pressure	0.345 to 0.689	MPa
Screw Speed	40 to 70	rpm
Vent Depth	0.038 to 0.076	mm

NOTE

1.	50 mm/min
2.	Type I, 50 mm/min
3.	Type I, 50 mm/min
4.	Type I, 50 mm/min
5.	Type I, 50 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	80*10*4
10.	Rate B (120°C/h), Loading 2 (50 N)

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