

LNP™ LUBRICOMP™ KFI15 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP LUBRICOMP KFI15 is a compound based on Acetal containing 25% Glass Fiber, 2% Silicone. Added feature of this grade is: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound KFL-4415

Product reorder name: KFI15

General Information			
Filler / Reinforcement	Glass Fiber,25% Filler by Weight		
Additive	Silicone Lubricant (2%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.56	g/cm ³	
--	1.50	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.70 to 0.90	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption (24 hr, 50% RH)	0.18	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	9260	MPa	ASTM D638
--	8720	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	112	MPa	ASTM D638
Break ³	102	MPa	ASTM D638
Break	118	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.9	%	ASTM D638
Break ⁵	2.0	%	ASTM D638
Break	2.4	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	7850	MPa	ASTM D790
-- ⁷	8020	MPa	ISO 178
Flexural Stress			
--	172	MPa	ISO 178
Yield, 50.0 mm Span ⁸	180	MPa	ASTM D790

Break, 50.0 mm Span ⁹	176	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	76	J/m	ASTM D256
23°C ¹⁰	8.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	540	J/m	ASTM D4812
23°C ¹¹	37	kJ/m ²	ISO 180/1U
Instrumented Dart Impact (23°C, Total Energy)	10.0	J	ASTM D3763
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	163	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹²	163	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	161	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹³	159	°C	ISO 75-2/Af
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.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	1.3 mm/min		
9.	1.3 mm/min		
10.	80*10*4		
11.	80*10*4		
12.	80*10*4 mm		
13.	80*10*4 mm		

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