

LNP™ LUBRICOMP™ SG004 compound

Polyamide 12

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP SG004 is a compound based on PA 12 resin containing Graphite. Added features include: Internally Lubricated.

General Information			
Additive	Graphite Powder Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage - Flow	1.1	%	Internal Method
Water Absorption (23°C, 24 hr)	0.14	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2400	MPa	ISO 527-2/1
Tensile Stress (Yield)	43.0	MPa	ISO 527-2/5
Tensile Strain (Break)	6.6	%	ISO 527-2/5
Flexural Modulus ¹	2300	MPa	ISO 178
Flexural Stress	66.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.41		
vs. Itself - Static	0.31		
Wear Factor - Washer	446	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	147	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	74.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	7.2E-5	cm/cm/°C	
Transverse : 23 to 60°C	9.0E-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	216 to 227	°C	

Middle Temperature	221 to 232	°C
Front Temperature	227 to 238	°C
Processing (Melt) Temp	227 to 238	°C
Mold Temperature	71.1 to 82.2	°C
Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 80*10*4 mm |

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