

LNP™ LUBRICOMP™ CX94108 compound

High Impact Polystyrene

SABIC Innovative Plastics Europe

Message:

LNP* LUBRICOMP* CX94108 is a compound based on Polystyrene resin containing Proprietary Lubricant. Added features include: Internally Lubricated.

General Information			
Additive	Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.08	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.60 to 0.80	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	3600	MPa	ISO 527-2/1
Tensile Stress (Break)	41.0	MPa	ISO 527-2/5
Tensile Strain (Break)	1.8	%	ISO 527-2/5
Flexural Modulus ¹	3500	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	72.0	MPa	
-- ⁴	69.0	MPa	
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.60		
vs. Itself - Static	0.71		
Wear Factor - Washer	365	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵ (23°C)	2.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁶ (23°C)	10	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷			
0.45 MPa, Unannealed, 64.0 mm Span	86.0	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	80.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	221 to 232	°C	
Middle Temperature	243 to 254	°C	
Front Temperature	266 to 277	°C	
Processing (Melt) Temp	249	°C	

Mold Temperature	37.8 to 65.6	°C
Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm

NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	
3.	Yield	
4.	Break	
5.	80*10*4	
6.	80*10*4	
7.	80*10*4 mm	

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