

LNP™ LUBRICOMP™ KL003E compound

Acetal (POM) Copolymer

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP KL003E is a compound based on Acetal Copolymer resin containing PTFE. Added features include: Internally Lubricated, Easy Molding.

General Information			
Additive	PTFE Lubricant		
Features	Good Moldability		
	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.48	g/cm ³	ISO 1183
Molding Shrinkage - Flow	2.9	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2300	MPa	ISO 527-2/1
Tensile Stress (Yield)	45.0	MPa	ISO 527-2/5
Tensile Strain (Yield)	11	%	ISO 527-2/5
Flexural Modulus ¹	2100	MPa	ISO 178
Flexural Stress	65.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	5.0	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 (1.8 MPa, Unannealed, 64.0 mm Span)	83.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	1.2E-4	cm/cm/°C	
Transverse : 23 to 60°C	1.3E-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.	2.0 mm/min	
2.	80*10*4	
3.	80*10*4	
4.	80*10*4 mm	

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