

LNP™ LUBRICOMP™ IL004 compound

Polyamide 612
SABIC Innovative Plastics

Message:

LNP LUBRICOMP IL004 is a compound based on Nylon 6/12 resin containing PTFE. Added features of this material include: Internally Lubricated.
Also known as: LNP* LUBRICOMP* Compound IL-4040
Product reorder name: IL004

General Information			
Additive	PTFE lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.18	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	1.7 - 1.9	%	ASTM D955
Transverse flow: 24 hours	1.7 - 1.9	%	ASTM D955
Vertical flow direction: 24 hours	1.8	%	ISO 294-4
Flow direction: 24 hours	1.8	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2070	MPa	ASTM D638
--	2190	MPa	ISO 527-2/1
Tensile Strength			
Yield	47.6	MPa	ASTM D638
Yield	49.0	MPa	ISO 527-2
Fracture	47.6	MPa	ASTM D638
Fracture	49.0	MPa	ISO 527-2
Tensile Elongation			
Yield	14	%	ASTM D638
Yield	15	%	ISO 527-2
Fracture	14	%	ASTM D638
Fracture	16	%	ISO 527-2
Flexural Modulus			
--	2070	MPa	ASTM D790
--	2000	MPa	ISO 178
Flexural Stress	65.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
With self-dynamics	0.25		ASTM D3702 Modified
With Self-Static	0.27		ASTM D3702 Modified

Wear Factor - Washer	18.5	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	37	J/m	ASTM D256
23°C ²	4.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	570	J/m	ASTM D4812
23°C ³	40	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	3.10	J	ASTM D3763
--	0.500	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	158	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁴	155	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	61.7	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	64.0	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 - 0.20	%	
Rear Temperature	254 - 266	°C	
Middle Temperature	260 - 271	°C	
Front Temperature	271 - 282	°C	
Processing (Melt) Temp	271 - 277	°C	
Mold Temperature	65.6 - 93.3	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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