

LNP™ LUBRICOMP™ IFL36R compound

Polyamide 612

SABIC Innovative Plastics Europe

Message:

Internally lubricated PA6.12, containing Glass Fiber and PTFE

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	PTFE Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.42	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8700	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	148	MPa	
Break	147	MPa	
Tensile Strain			ISO 527-2/5
Yield	3.3	%	
Break	3.4	%	
Flexural Modulus ¹	7300	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	200	MPa	
-- ⁴	198	MPa	
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.55		
vs. Itself - Static	0.50		
Wear Factor - Washer	9.00	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁵ (23°C)	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁶ (23°C)	70	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁷ (1.8 MPa, Unannealed, 64.0 mm Span)	197	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.8E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.0E-4	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	254 to 266	°C
Middle Temperature	260 to 271	°C
Front Temperature	271 to 282	°C
Processing (Melt) Temp	271 to 277	°C
Mold Temperature	65.6 to 93.3	°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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