

LNP™ LUBRICOMP™ MX06404 compound

Polypropylene
SABIC Innovative Plastics

Message:

LNP LUBRICOMP* MX06404 is a compound based on Polypropylene resin containing 20% Glass Fiber and 15% PTFE. Added features of this material include: Heat Stabilized, Low Extractable, Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound MFL-4034 HS LE

Product reorder name: MX06404

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
	PTFE Fiber,15% Filler by Weight		
Additive	Heat Stabilizer		
Features	Good Wear Resistance		
	Heat Stabilized		
	Low Extractables		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
	1.13		
Specific Gravity	1.13	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.70 to 0.90	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.13	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.070	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5730	MPa	ASTM D638
--	5320	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	39.0	MPa	ASTM D638
Yield	38.0	MPa	ISO 527-2/5
Break ³	33.0	MPa	ASTM D638
Break	36.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	1.2	%	ASTM D638

Yield	1.1	%	ISO 527-2/5
Break ⁵	1.6	%	ASTM D638
Break	1.5	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	4480	MPa	ASTM D790
-- ⁷	4590	MPa	ISO 178
Flexural Stress			
--	59.0	MPa	ISO 178
Yield, 50.0 mm Span ⁸	61.0	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.30		
vs. Itself - Static	0.28		
Wear Factor			ASTM D3702 Modified
Ring	1.00	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	61.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	41	J/m	ASTM D256
23°C ⁹	3.4	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	150	J/m	ASTM D4812
23°C ¹⁰	10	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	11.0	J	ASTM D3763
--	2.80	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	145	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹¹	135	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	103	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	97.0	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.1E-5	cm/cm/°C	
Transverse : -30 to 30°C	8.4E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	193 to 204	°C	
Middle Temperature	216 to 227	°C	
Front Temperature	238 to 249	°C	
Processing (Melt) Temp	227 to 249	°C	
Mold Temperature	32.2 to 48.9	°C	

Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm

NOTE		
1.	5.0 mm/min	
2.	Type I, 5.0 mm/min	
3.	Type I, 5.0 mm/min	
4.	Type I, 5.0 mm/min	
5.	Type I, 5.0 mm/min	
6.	1.3 mm/min	
7.	2.0 mm/min	
8.	1.3 mm/min	
9.	80*10*4	
10.	80*10*4	
11.	80*10*4 mm	
12.	80*10*4 mm	

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