

LNP™ LUBRICOMP™ EX06405 compound

Polyether Imide

SABIC Innovative Plastics

Message:

LNP LUBRICOMP EX06405 is a compound based on Polyetherimide resin containing Glass Fiber, PTFE. Added features of this material include: Internally Lubricated, Low Extractible.

Also known as: LNP* LUBRICOMP* Compound EFL-4034 EM LE

Product reorder name: EX06405

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	PTFE lubricant		
Features	Low extract		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.53	g/cm ³	ASTM D792
--	1.52	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.30 - 0.50	%	ASTM D955
Transverse flow: 24 hours	0.40 - 0.60	%	ASTM D955
Vertical flow direction: 24 hours	0.51	%	ISO 294-4
Flow direction: 24 hours	0.42	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7580	MPa	ASTM D638
--	7140	MPa	ISO 527-2/1
Tensile Strength			
Yield	123	MPa	ASTM D638
Yield	119	MPa	ISO 527-2
Fracture	123	MPa	ASTM D638
Fracture	119	MPa	ISO 527-2
Tensile Elongation			
Yield	2.4	%	ASTM D638
Yield	2.5	%	ISO 527-2
Fracture	2.4	%	ASTM D638
Fracture	2.5	%	ISO 527-2
Flexural Modulus			

--	6890	MPa	ASTM D790
--	6900	MPa	ISO 178
Flexural Strength			
--	152	MPa	ASTM D790
--	169	MPa	ISO 178
Coefficient of Friction			
With self-dynamics	0.44		ASTM D3702 Modified
With Self-Static	0.52		ASTM D3702 Modified
Wear Factor - Washer	69.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	69	J/m	ASTM D256
23°C ²	7.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	490	J/m	ASTM D4812
23°C ³	31	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	11.8	J	ASTM D3763
--	3.70	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	209	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁴	211	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	202	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	204	°C	ISO 75-2/Af
Linear thermal expansion coefficient			
Flow: -40 to 40°C	3.6E-5	cm/cm/°C	ASTM E831
Flow: -40 to 40°C	3.5E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	3.6E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	3.7E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	121 - 149	°C	
Drying Time	4.0 - 6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	343 - 354	°C	
Middle Temperature	354 - 366	°C	
Front Temperature	366 - 377	°C	
Processing (Melt) Temp	360 - 366	°C	
Mold Temperature	121 - 149	°C	
Back Pressure	0.344 - 0.689	MPa	
Screw Speed	60 - 100	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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