

LNP™ LUBRICOMP™ EX06405 compound

Polyether Imide

SABIC Innovative Plastics

Message:

LNP LUBRICOMP EX06405 is a compound based on Polyetherimide resin containing 20% Glass Fiber, 15% PTFE. Added features of this material include: Wear Resistant, Low Extractible, Easy Molding.

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

Product reorder name: EX06405

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	PTFE Lubricant (15%)		
Features	Good Moldability		
	Good Wear Resistance		
	Low Extractables		
	Lubricated		
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 hr	0.30 to 0.50	%	ASTM D955
Across Flow : 24 hr	0.40 to 0.60	%	ASTM D955
Across Flow : 24 hr	0.51	%	ISO 294-4
Flow : 24 hr	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
Break	123	MPa	ASTM D638
Break	119	MPa	ISO 527-2
Tensile Elongation			
Yield	2.4	%	ASTM D638
Yield	2.5	%	ISO 527-2
Break	2.4	%	ASTM D638

Break	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			
vs. Itself - Dynamic	0.44		
vs. Itself - Static	0.52		
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, 3.20 mm	209	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	211	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	202	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	204	°C	ISO 75-2/Af
CLTE			
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
Transverse : -40 to 40°C	3.6E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	3.7E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	121 to 149	°C	
Drying Time	4.0 to 6.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	343 to 354	°C	
Middle Temperature	354 to 366	°C	
Front Temperature	366 to 377	°C	
Processing (Melt) Temp	360 to 366	°C	
Mold Temperature	121 to 149	°C	
Back Pressure	0.344 to 0.689	MPa	

Screw Speed	60 to 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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