

LNP™ LUBRICOMP™ HAL23 compound

Polyamide 11

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP HAL23 is a compound based on PA 11 resin containing Aramid Fiber, PTFE. Added features include: Internally Lubricated.

General Information			
Filler / Reinforcement	Aramid Fiber		
Additive	PTFE Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.14	g/cm ³	ISO 1183
Molding Shrinkage - Flow	1.1	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	1400	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	45.0	MPa	
Break	42.0	MPa	
Tensile Strain (Yield)	17	%	ISO 527-2/5
Flexural Modulus ¹	1900	MPa	ISO 178
Flexural Stress	54.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	7.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	40	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	174	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	72.0	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	8.0E-5	cm/cm/°C	
Transverse : 23 to 60°C	1.4E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.15	%	
Rear Temperature	199 to 210	°C	
Middle Temperature	232 to 243	°C	
Front Temperature	260 to 271	°C	

Processing (Melt) Temp	227 to 260	°C
Mold Temperature	43.3 to 54.4	°C
Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm

NOTE

- | | |
|----|------------|
| 1. | 2.0 mm/min |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 80*10*4 mm |

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