

LNP™ LUBRICOMP™ KFL23LH compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP LUBRICOMP* KFL23LH is a compound based on Acetal Copolymer resin containing 15% Glass Fiber, 10% PTFE. Added features of this material include: Wear Resistant, Low Extractable.

Also known as: LNP* LUBRICOMP* Compound KFL-4023 LE

Product reorder name: KFL23LH

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Additive	PTFE Lubricant (10%)		
Features	Good Wear Resistance		
	Low Extractables		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.58	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.90 to 2.0	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.21	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.34	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6730	MPa	ASTM D638
--	6820	MPa	ISO 527-2/1
Tensile Strength			
Break ²	78.0	MPa	ASTM D638
Break	75.0	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.9	%	ASTM D638
Break	1.8	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	5740	MPa	ASTM D790
-- ⁵	5910	MPa	ISO 178
Flexural Stress			
--	108	MPa	ISO 178
Yield, 50.0 mm Span ⁶	119	MPa	ASTM D790

Break, 50.0 mm Span ⁷	107	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	51	J/m	ASTM D256
23°C ⁸	4.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	350	J/m	ASTM D4812
23°C ⁹	22	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.8	J	ASTM D3763
--	2.60	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	163	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	163	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	162	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	158	°C	ISO 75-2/Af
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	177 to 188	°C	
Middle Temperature	193 to 204	°C	
Front Temperature	210 to 221	°C	
Processing (Melt) Temp	199 to 216	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	1.3 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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