

LNP™ LUBRICOMP™ QL004 compound

Polyamide 610

SABIC Innovative Plastics

Message:

LNP LUBRICOMP QL004 is a compound based on Nylon 6/10 containing 20% PTFE. Added features of this grade include: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound QL-4040

Product reorder name: QL004

General Information			
Additive	PTFE Lubricant (20%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	1.0 to 3.0	%	
Across Flow : 24 hr	1.0 to 3.0	%	
Water Absorption			
24 hr, 50% RH	0.26	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.37	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2430	MPa	ASTM D638
--	2490	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	53.0	MPa	ASTM D638
Yield	53.0	MPa	ISO 527-2/5
Break ³	53.0	MPa	ASTM D638
Break	52.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	14	%	ASTM D638
Yield	11	%	ISO 527-2/5
Break ⁵	16	%	ASTM D638
Break	11	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	1710	MPa	ASTM D790
-- ⁷	2320	MPa	ISO 178
Flexural Stress	50.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method

Notched Izod Impact			
23°C	39	J/m	ASTM D256
23°C ⁸	4.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	680	J/m	ASTM D4812
23°C ⁹	32	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	3.20	J	ASTM D3763
--	1.40	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	181	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	170	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	56.0	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	60.0	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	1.1E-4	cm/cm/°C	
Transverse : -30 to 30°C	1.1E-4	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.12 to 0.20	%	
Rear Temperature	249 to 260	°C	
Middle Temperature	260 to 271	°C	
Front Temperature	271 to 282	°C	
Processing (Melt) Temp	271 to 277	°C	
Mold Temperature	82.2 to 93.3	°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.	Type I, 5.0 mm/min		
5.	Type I, 5.0 mm/min		
6.	1.3 mm/min		
7.	2.0 mm/min		
8.	80*10*4		
9.	80*10*4		
10.	80*10*4 mm		
11.	80*10*4 mm		

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