

LNP™ LUBRICOMP™ KFL36 compound

Acetal (POM) Copolymer

SABIC Innovative Plastics

Message:

LNP LUBRICOMP KFL36 is a compound based on Acetal Copolymer resin containing Glass Fiber, PTFE. Added features of this material include: Internally Lubricated.
Also known as: LNP* LUBRICOMP* Compound KFL-4036
Product reorder name: KFL36

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	PTFE lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.75	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.70 - 1.0	%	ASTM D955
Transverse flow: 24 hours	1.0 - 3.0	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.16	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.26	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	10800	MPa	ASTM D638
--	10600	MPa	ISO 527-2/1
Tensile Strength			
Fracture ²	88.0	MPa	ASTM D638
Fracture	84.0	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ³	1.3	%	ASTM D638
Fracture	1.3	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁴	9280	MPa	ASTM D790
-- ⁵	9930	MPa	ISO 178
Flexural Stress			
--	130	MPa	ISO 178
Fracture, 50.0mm span ⁶	107	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
With self-dynamics	0.40		ASTM D3702 Modified
With Self-Static	0.46		ASTM D3702 Modified

Wear Factor - Washer	235	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	50	J/m	ASTM D256
23°C ⁷	5.9	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁸ (23°C)	25	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	10.3	J	ASTM D3763
--	2.50	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	183	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁹	163	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	161	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹⁰	161	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM D696
Flow: -30 to 30°C	9.5E-5	cm/cm/°C	ASTM D696
Lateral: -30 to 30°C	6.5E-5	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	4.0	hr	
Rear Temperature	177 - 188	°C	
Middle Temperature	193 - 204	°C	
Front Temperature	210 - 221	°C	
Processing (Melt) Temp	199 - 216	°C	
Mold Temperature	82.2 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 5.0 mm/min		
4.	1.3 mm/min		
5.	2.0 mm/min		
6.	1.3 mm/min		
7.	80*10*4		
8.	80*10*4		
9.	80*10*4 mm		
10.	80*10*4 mm		

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