

LNPT[™] LUBRICOMP[™] COMPOUND WAL34I

WAL-4034 NAT

DESCRIPTION

LNP LUBRICOMP WAL34I compound is based on Polybutylene Terephthalate (PBT) resin containing 15% PTFE, 20% aramid fiber. Added features of this grade include: Internally Lubricated, Wear Resistant, Impact Modified

GENERAL INFORMATION	
Features	Wear resistant, Impact resistant
Fillers	Aramid Fiber, PTFE
Polymer Types	Polybutylene Terephthalate (PBT)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component
Consumer	Sport/Leisure, Personal Accessory, Home Appliances, Commercial Appliance
Electrical and Electronics	Mobile Phone - Computer - Tablets
Industrial	Electrical

TYPICAL PROPERTY VALUES

Revision 20231109

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, break, 5 mm/min	58	MPa	ISO 527
Tensile Strain, break, 5 mm/min	4.9	%	ISO 527
Flexural Stress, yield, 2 mm/min	80	MPa	ISO 178
Flexural Modulus, 2 mm/min	3200	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, unnotched 80*10*4 +23°C	30	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
CTE, 23°C to 60°C, flow	5.8E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	1.3E-04	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	217	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	149	°C	ISO 75/Af
PHYSICAL ⁽¹⁾			
Mold Shrinkage, flow ⁽²⁾	0.77	%	SABIC method
Wear Factor Washer	53	10 ⁻⁴ -10 in ³ -min/ft-lb-hr	ASTM D3702 Modified: Instr.
Dynamic COF	0.34	-	ASTM D3702 Modified: Instr.
Static COF	0.39	-	ASTM D3702 Modified: Instr.
Density	1.4	g/cm ³	ISO 1183
INJECTION MOLDING ⁽³⁾			
Drying Temperature	120	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4	Hrs	
Maximum Moisture Content	0.05	%	
Melt Temperature	240 – 265	°C	
Front - Zone 3 Temperature	260 – 270	°C	
Middle - Zone 2 Temperature	245 – 255	°C	
Rear - Zone 1 Temperature	220 – 230	°C	
Mold Temperature	80 – 100	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

- (1) The information stated on Technical Datasheets should be used as indicative only for material selection purposes and not be utilized as specification or used for part or tool design.
- (2) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.
- (3) Injection Molding parameters are only mentioned as general guidelines. These may not apply or may need adjustment in specific situations such as low shot sizes, large part molding, thin wall molding and gas-assist molding.

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