

# LNPTM LUBRICOMPTM COMPOUND QFL32

QFL-4032

## DESCRIPTION

LNP LUBRICOMP QFL32 compound is based on Nylon 6/10 resin containing 10% glass fiber, 15% PTFE. Added features of this grade include: Wear Resistant.

GENERAL INFORMATION	
Features	Wear resistant
Fillers	Glass Fiber, PTFE
Polymer Types	Polyamide 610 (Nylon 610)
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
<b>MECHANICAL <sup>(1)</sup></b>			
Tensile Stress, brk, Type I, 5 mm/min	85	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	3.1	%	ASTM D638
Tensile Modulus, 50 mm/min	4680	MPa	ASTM D638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	134	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	3850	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	86	MPa	ISO 527
Tensile Stress, break, 5 mm/min	79	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3	%	ISO 527
Tensile Modulus, 1 mm/min	4440	MPa	ISO 527
Flexural Stress	128	MPa	ISO 178
Flexural Modulus, 2 mm/min	3880	MPa	ISO 178
<b>IMPACT <sup>(1)</sup></b>			
Izod Impact, unnotched, 23°C	367	J/m	ASTM D4812
Izod Impact, notched, 23°C	38	J/m	ASTM D256
Multiaxial Impact	1	J	ISO 6603
Instrumented Dart Impact Total Energy, 23°C	5	J	ASTM D3763
Izod Impact, unnotched 80°10°4 +23°C	23	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80°10°4 +23°C	1	kJ/m <sup>2</sup>	ISO 180/1A
<b>THERMAL <sup>(1)</sup></b>			
HDT, 0.45 MPa, 3.2 mm, unannealed	218	°C	ASTM D648
HDT, 1.82 MPa, 3.2mm, unannealed	196	°C	ASTM D648

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -30°C to 30°C, flow	5.6E-05	1/°C	ASTM D696
CTE, -30°C to 30°C, xflow	1.2E-04	1/°C	ASTM D696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	215	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	189	°C	ISO 75/Af
<b>PHYSICAL <sup>(1)</sup></b>			
Specific Gravity	1.25	-	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.24	%	ASTM D570
Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>	0.7 – 0.9	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs <sup>(2)</sup>	1 – 3	%	ASTM D955
Wear Factor Washer	48	10 <sup>-10</sup> in <sup>4</sup> -min/ft-lb-hr	ASTM D3702 Modified: Manual
Wear Factor Ring	5	10 <sup>-10</sup> in <sup>4</sup> -min/ft-lb-hr	ASTM D3702 Modified: Manual
Dynamic COF	0.42	-	ASTM D3702 Modified: Manual
Static COF	0.38	-	ASTM D3702 Modified: Manual
Density	1.25	g/cm <sup>3</sup>	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.34	%	ISO 62
<b>INJECTION MOLDING <sup>(3)</sup></b>			
Drying Temperature	80	°C	
Drying Time	4	Hrs	
Maximum Moisture Content	0.12 – 0.2	%	
Melt Temperature	270 – 275	°C	
Front - Zone 3 Temperature	270 – 280	°C	
Middle - Zone 2 Temperature	260 – 270	°C	
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	80 – 95	°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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