

# LNPT<sup>™</sup> LUBRICOMP<sup>™</sup> COMPOUND XFL21R

XFL-4021 MR

## DESCRIPTION

LNP LUBRICOMP XFL21R compound is based on Amorphous Nylon resin containing 5% glass fiber, 10% PTFE. Added features of this grade include: Wear Resistant, Mold Release.

GENERAL INFORMATION	
Features	Wear resistant, Enhanced mold release
Fillers	Glass Fiber, PTFE
Polymer Types	Polyamide, Unspecified (Nylon, Unspecified)
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, break	84	MPa	ASTM D638
Tensile Strain, break	4.1	%	ASTM D638
Tensile Modulus, 50 mm/min	3730	MPa	ASTM D638
Flexural Stress	131	MPa	ASTM D790
Flexural Modulus	3900	MPa	ASTM D790
<b>IMPACT <sup>(1)</sup></b>			
Izod Impact, unnotched, 23°C	506	J/m	ASTM D4812
Izod Impact, notched, 23°C	58	J/m	ASTM D256
<b>THERMAL <sup>(1)</sup></b>			
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D648
<b>PHYSICAL <sup>(1)</sup></b>			
Density	1.21	g/cm <sup>3</sup>	ASTM D792
Mold Shrinkage, flow, 24 hrs <sup>(2)</sup>	0.7	%	ASTM D955
<b>INJECTION MOLDING <sup>(3)</sup></b>			
Drying Temperature	100 – 120	°C	
Drying Time	6 – 12	Hrs	
Maximum Moisture Content	0.1	%	
Melt Temperature	260 – 300	°C	
Front - Zone 3 Temperature	290 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Rear - Zone 1 Temperature	260 – 270	°C	
Mold Temperature	50 – 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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