LNP™ LUBRICOMP™ COMPOUND QP004

QL-4540

DESCRIPTION

LNP LUBRICOMP QP004 compound is based on Nylon 6/10 resin containing 20% PTFE/silicone. Added features of this grade include: Wear Resistant.

GENERAL INFORMATION	
Features	Wear resistant
Fillers	Unreinforced, PTFE/Silicone
Polymer Types	Polyamide 610 (Nylon 610)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Building and Construction	Building Component, Water Management
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, yld, Type I, 5 mm/min	48	MPa	ASTM D638
Tensile Stress, brk, Type I, 5 mm/min	48	MPa	ASTM D638
Tensile Strain, yld, Type I, 5 mm/min	10.5	%	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	10.9	%	ASTM D638
Tensile Modulus, 50 mm/min	2230	MPa	ASTM D638
Flexural Modulus, 1.3 mm/min, 50 mm span	2040	MPa	ASTM D790
Tensile Stress, yield, 5 mm/min	48	MPa	ISO 527
Tensile Stress, break, 5 mm/min	47	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	9	%	ISO 527
Tensile Strain, break, 5 mm/min	9.2	%	ISO 527
Tensile Modulus, 1 mm/min	2170	MPa	ISO 527
Flexural Stress	69	MPa	ISO 178
Flexural Modulus, 2 mm/min	1990	MPa	ISO 178
IMPACT [1]			
Izod Impact, unnotched, 23°C	414	J/m	ASTM D4812
Izod Impact, notched, 23°C	29	J/m	ASTM D256
Instrumented Dart Impact Total Energy, 23°C	3	J	ASTM D3763
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m²	ISO 180/1A
THERMAL [1]			
HDT, 0.45 MPa, 3.2 mm, unannealed	170	°C	ASTM D648

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT, 1.82 MPa, 3.2mm, unannealed	57	°C	ASTM D648
CTE, -30°C to 30°C, flow	1.13E-04	1/°C	ASTM D696
CTE, -30°C to 30°C, xflow	1.08E-04	1/°C	ASTM D696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	55	°C	ISO 75/Af
PHYSICAL (1)			
Specific Gravity	1.19	-	ASTM D792
Density	1.19	g/cm³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.33	%	ASTM D570
Mold Shrinkage, flow, 24 hrs (2)	1 – 4	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs (2)	1 – 4	%	ASTM D955
Wear Factor Washer	4	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified: Manual
Wear Factor Ring	-1	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified: Manual
Dynamic COF	0.26	-	ASTM D3702 Modified: Manual
Static COF	0.1	-	ASTM D3702 Modified: Manual
Moisture Absorption (23°C / 50% RH)	0.51	%	ISO 62
INJECTION MOLDING (3)			
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.

DISCLAIMER