

LNPTM LUBRICOMPTM COMPOUND KFL25

KFL-4025

DESCRIPTION

LNP LUBRICOMP KFL25 compound is based on Acetal (POM) Copolymer resin containing 25% glass fiber, 10% PTFE. Added features of this grade include: Wear Resistant.

GENERAL INFORMATION	
Features	Wear resistant
Fillers	Glass Fiber, PTFE
Polymer Types	Acetal (POM) Copolymer
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	85	MPa	ASTM D638
Tensile Strain, break	1.3	%	ASTM D638
Tensile Modulus, 50 mm/min	10240	MPa	ASTM D638
Flexural Stress	131	MPa	ASTM D790
Flexural Modulus	9100	MPa	ASTM D790
Tensile Stress, break	84	MPa	ISO 527
Tensile Strain, break	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	9870	MPa	ISO 527
Flexural Stress	130	MPa	ISO 178
Flexural Modulus	9200	MPa	ISO 178
IMPACT ⁽¹⁾			
Izod Impact, unnotched, 23°C	293	J/m	ASTM D4812
Izod Impact, notched, 23°C	48	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	8	J	ASTM D3763
Multiaxial Impact	1	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	18	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL ⁽¹⁾			
HDT, 1.82 MPa, 3.2mm, unannealed	165	°C	ASTM D648
CTE, -40°C to 40°C, flow	6.33E-05	1 /°C	ASTM E831

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CTE, -40°C to 40°C, xflow	8.22E-05	1/°C	ASTM E831
CTE, -40°C to 40°C, flow	6.32E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	8.26E-05	1/°C	ISO 11359-2
PHYSICAL ⁽¹⁾			
Density	1.65	g/cm ³	ASTM D792
Moisture Absorption, (23°C/50% RH/24 hrs)	0.19	%	ASTM D570
Mold Shrinkage, flow, 24 hrs ⁽²⁾	0.5	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs ⁽²⁾	1	%	ASTM D955
Mold Shrinkage, flow, 24 hrs ⁽²⁾	0.5	%	ISO 294
Mold Shrinkage, xflow, 24 hrs ⁽²⁾	0.96	%	ISO 294
Density	1.65	g/cm ³	ISO 1183
INJECTION MOLDING ⁽³⁾			
Drying Temperature	80	°C	
Drying Time	4	Hrs	
Melt Temperature	200 – 215	°C	
Front - Zone 3 Temperature	210 – 220	°C	
Middle - Zone 2 Temperature	195 – 205	°C	
Rear - Zone 1 Temperature	175 – 190	°C	
Mold Temperature	80 – 110	°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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