

LNPTM LUBRICOMPTM COMPOUND EX10405H

DESCRIPTION

LNP LUBRICOMP EX10405H compound is based on Polyetherimide (PEI) resin containing 30% carbon and proprietary lubricant.. Added features of this grade include: Wear Resistant, Healthcare.

GENERAL INFORMATION	
Features	Wear resistant, Healthcare/Formula lock, High temperature resistance
Fillers	Carbon Fiber
Polymer Types	Polyetherimide (PEI)
Processing Techniques	Injection Molding

INDUSTRY	SUB INDUSTRY
Hygiene and Healthcare	Pharmaceutical Packaging and Drug Delivery, Surgical devices, General Healthcare, Patient Testing
Packaging	Industrial Packaging

TYPICAL PROPERTY VALUES

Revision 20241017

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL ⁽¹⁾			
Tensile Stress, brk, Type I, 5 mm/min	216	MPa	ASTM D638
Tensile Strain, brk, Type I, 5 mm/min	1.3	%	ASTM D638
Tensile Modulus, 5 mm/min	21540	MPa	ASTM D638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	283	MPa	ASTM D790
Flexural Modulus, 1.3 mm/min, 50 mm span	17300	MPa	ASTM D790
IMPACT ⁽¹⁾			
Izod Impact, unnotched, 23°C	476	J/m	ASTM D4812
Izod Impact, notched, 23°C	56	J/m	ASTM D256
THERMAL ⁽¹⁾			
HDT, 1.82 MPa, 3.2mm, unannealed	213	°C	ASTM D648
PHYSICAL ⁽¹⁾			
Wear Factor Washer	22	10 ⁻¹⁰ in ⁴ 5-min/ft-lb-hr	ASTM D3702 Modified: Manual
Dynamic COF	0.38	-	ASTM D3702 Modified: Manual
Static COF	0.44	-	ASTM D3702 Modified: Manual
Specific Gravity	1.4	-	ASTM D792
INJECTION MOLDING ⁽²⁾			
Drying Temperature	150	°C	
Drying Time	4 – 6	Hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	360 – 400	°C	
Rear - Zone 1 Temperature	360 – 380	°C	
Middle - Zone 2 Temperature	370 – 390	°C	
Front - Zone 3 Temperature	380 – 400	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Nozzle Temperature	390 – 400	°C	
Mold Temperature	140 – 180	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw speed (Circumferential speed)	0.2 – 0.3	m/s	
Vent Depth	0.025 – 0.076	mm	

- (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) 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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