

## LNPTM LUBRICOMPTM COMPOUND OFL36

OFL-4036 REGION ASIA

## **DESCRIPTION**

LNP LUBRICOMP OFL36 compound is based on Polyphenylene Sulfide (PPS) - linear resin containing 30% glass fiber, 15% PTFE. Added features of this grade include: Wear Resistant.

GENERAL INFORMATION	
Features	Wear resistant, High stiffness/Strength
Fillers	Glass Fiber, PTFE
Polymer Types	Polyphenylene Sulfide, Linear (PPS, Linear)
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 20241017

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL (1)			
Tensile Stress, break	145	MPa	ASTM D638
Tensile Strain, break	1.7	%	ASTM D638
Tensile Modulus, 50 mm/min	12600	MPa	ASTM D638
Flexural Stress	200	MPa	ASTM D790
Flexural Modulus	11030	MPa	ASTM D790
Tensile Stress, break	124	MPa	ISO 527
Tensile Strain, break	1.4	%	ISO 527
Tensile Modulus, 1 mm/min	11500	MPa	ISO 527
Flexural Stress	197	MPa	ISO 178
Flexural Modulus	10950	MPa	ISO 178
IMPACT (1)			
Izod Impact, unnotched, 23°C	550	J/m	ASTM D4812
Izod Impact, notched, 23°C	85	J/m	ASTM D256
Instrumented Dart Impact Energy @ peak, 23°C	3	J	ASTM D3763
Multiaxial Impact	1	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	kJ/m²	ISO 180/1A
THERMAL (1)			
HDT, 1.82 MPa, 3.2mm, unannealed	266	°C	ASTM D648



PROPERTIES         TYPICAL VALUES         UNITS         EST METHODS           CTE, 40°Ct to 40°C, flow         4,860°C to 40°C, flow         4,860°C to 40°C, flow         4,860°C to 40°C, flow         511893           CTE, 40°Ct to 40°C, flow         2,166°C to 40°C, flow         10°C         8011399-2           CTE, 40°Ct to 40°C, flow         51189-2         10°C         8011399-2           POPTION, 18 Mer Batts 9010°4 spe \$4mm         260°C         0°C         00.766°C           Relative Temp Index, Mech wijninpact <sup>10</sup> 130°C         "C         0.766°C           Relative Temp Index, Mech wijninpact <sup>10</sup> 130°C         "C         0.746°C           Relative Temp Index, Mech wijninpact <sup>10</sup> 130°C         "C         0.746°C           Relative Temp Index, Mech wijninpact <sup>10</sup> 130°C         "C         0.746°C           Relative Temp Index, Mech wijninpact <sup>10</sup> 130°C         "C         0.746°C           Medistrie Absorption (23°C 150°K 8H/24 hrs)         0.10°C         %         0.746°C           Mold Shrinkage, flow, 24 hrs <sup>10</sup> 0.10°C         %         0.746°C           Mold Shrinkage, flow, 24 hrs <sup>10</sup> 0.10°C         %         0.0294°C           Mold Shrinkage, flow, 24 hrs <sup>10</sup> 0.10°C         %         0.0294°C				
CFL, 40°C to 40°C, 160w         4860 50         1°C         MSI 1359-2           CFL, 40°C to 40°C, 160w         2.36°C 50         1°C         80 1359-2           CFL, 40°C to 40°C, 160w         200         1°C         1057. JA           CFL, 40°C to 40°C, 160w         200         0.07 5/A           Relative Temp Index, Elec 1°         200         0.0         10.746           Relative Temp Index, Mech w/Impact 1°         10         0.0         0.0         10.746           Relative Temp Index, Mech w/Impact 1°         10         0.0         0.0         10.746           Relative Temp Index, Mech w/Impact 1°         10         0.0         0.0         10.746           Relative Temp Index, Mech w/Impact 1°         10         0.0         0.0         0.0         10.0 <td< th=""><th>PROPERTIES</th><th>TYPICAL VALUES</th><th>UNITS</th><th>TEST METHODS</th></td<>	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
CFL -40°Ct co 40°C, cliow         2.360.50         11°C         50.135.90         11.350         2.00         11.350         2.00         11.350         2.00         11.350         2.00<	CTE, -40°C to 40°C, flow	0.0000234 - 0.00005003	1/°C	ASTM E831
CT. 4.0°C to 40°C, vidow         50.110.50         1,°°         50.113.59         1.00 (A)         1.00 (	CTE, -40°C to 40°C, xflow	4.86E-05	1/°C	ASTM E831
RIDT/AL 1.8 MPa Flatw 80*10*4 sp-64mm         266         ***C         17.4 fe8           Relative Temp Index, Blee*** (*)         200         **C         11.7 468           Relative Temp Index, Mech w/Impact*** (*)         130         **C         11.7 468           Relative Temp Index, Mech w/I impact*** (*)         130         **C         12.7 468           PHYSICAL*** (*)         **S         **C         1.7 468           Mold Shrinkage, flow, 24 fts** (*)         0.1         \$         ASTM D573           Mold Shrinkage, flow, 24 fts** (*)         0.3-0.2         \$         ASTM D575           Mold Shrinkage, flow, 24 fts** (*)         0.3-0.4         \$         ASTM D576           Mold Shrinkage, flow, 24 fts** (*)         0.3-0.4         \$         ASTM D576 McM           Mold Shrinkage, flow, 24 fts** (*)         0.3-0.4         \$         ASTM D576 McM           Mold Shrinkage, flow, 24 fts** (*)         0.3-0.4         \$         D52.9           Wear Factor Washer         3         0.0-1.0 in/5 init/1.0 th         ASTM D3762 Modifier: Manual D40.0 th           Mold Shrinkage, flow, 24 fts** (*)         1.0         \$         C         2.0           Wear Factor Washer         1.0         \$         C         2.0         ASTM D3762 Modifier: Manual D40.0 th	CTE, -40°C to 40°C, flow	2.36E-05	1/°C	ISO 11359-2
Relative Temp Index, Mech wijmpact (**)         200         ***C         U.**7468           Relative Temp Index, Mech wijmpact (**)         130         ***C         U.**7468           Relative Temp Index, Mech wijmpact (**)         130         ***C         U.**7468           Relative Temp Index, Mech wijmpact (**)         130         ***C         U.**C           Prins SCAL (**)         ***U         ***C         ASTM D978           Moist Department (**)         1.0         ***C         ASTM D978           Moid Shrinkage, flow, 24 hrs (**)         0.10         ***C         ASTM D978           Moid Shrinkage, flow, 24 hrs (**)         0.3         ***C         ASTM D978           Moid Shrinkage, flow, 24 hrs (**)         0.3         ***C         ***C         ASTM D978           Moid Shrinkage, flow, 24 hrs (**)         0.3         ***C         ***C         ASTM D978           Moid Shrinkage, flow, 24 hrs (**)         0.3         ***C         ***C         ASTM D978 Moidles Manual           Moid Shrinkage, flow, 24 hrs (**)         0.4         ***C         ASTM D978 Moidles Manual           Paramic COF         4         ***C         ASTM D978 Moidles Manual           State CoF         ***C         ***C         ***C           Boshita Faguati	CTE, -40°C to 40°C, xflow	5.01E-05	1/°C	ISO 11359-2
Relative Funding index, Michay impact (**)         130         ***         Ut 7468           Relative Funding Meck (**)         130         ***         Ut 7468           PHYSICAL****         ***         Ut 7468         ***           PHYSICAL****         **         ***         ***         ***         ***         ***         ***         ***         ***         *** <th>HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm</th> <th>266</th> <th>°C</th> <th>ISO 75/Af</th>	HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	266	°C	ISO 75/Af
Relative Franch (Information Principle)         1918 (1918)	Relative Temp Index, Elec <sup>(2)</sup>	200	°C	UL 746B
PortSICAL <sup>(1)</sup> PortSICAL (1)         Image of Motor (2)         ASTATO (2)         ASTATO (2)         ASTATO (2)         Motor (2)         ASTATO (2)         ASTATO (2)         ASTATO (2)         Motor (2)         ASTATO (2)	Relative Temp Index, Mech w/impact (2)	130	°C	UL 746B
Denisty1.72.7 <t< th=""><th>Relative Temp Index, Mech w/o impact (2)</th><th>130</th><th>°C</th><th>UL 746B</th></t<>	Relative Temp Index, Mech w/o impact (2)	130	°C	UL 746B
Moisture Absorption (23°C/508H)/24 hrs (1)         0.10         %         ASTM D950           Mold Shrinkage, flow, 24 hrs (1)         0.3 − 0.2         %         ASTM D955           Mold Shrinkage, flow, 24 hrs (1)         0.3 − 0.3         %         ASTM D950           Mold Shrinkage, flow, 24 hrs (1)         0.3 − 0.4         %         STM D950           Mold Shrinkage, flow, 24 hrs (1)         0.3 − 0.4         %         STM D3702 Modified: Manual D180           Mold Shrinkage, flow, 24 hrs (1)         0.3 − 0.4         %         STM D3702 Modified: Manual D180           Wear Factor Washer         0.3 − 0.0         %         D7 − 0.0         ASTM D3702 Modified: Manual D180           Dynamic COF         0.4         0.4         − 0.0         ASTM D3702 Modified: Manual D180           Bostive Absorption (23°C / 50% Rh)         0.3         0.2         0.0	PHYSICAL (1)			
Mold Shrinkage, flow, 24 hrs (1)0.1 – 0.2%ASTM D95Mold Shrinkage, flow, 24 hrs (1)0.3 – 0.5%STM D95Mold Shrinkage, flow, 24 hrs (1)0.1 – 0.18%STM D95Mold Shrinkage, flow, 24 hrs (1)0.1 – 0.18%STM D3702 Modified: Manual DisplayMold Shrinkage, flow, 24 hrs (1)0.3 – 0.4810 – 0.1 in 5-min/Hub MASTM D3702 Modified: Manual DisplayWear Factor Washer0.41 – 0.1 in 5-min/Hub MASTM D3702 Modified: Manual DisplayDynamic COF0.42 – 0.2ASTM D3702 Modified: Manual DisplayBobiture Aborption (23° C J SW Rh)0.23.5Modified: Manual DisplayDensity0.20.20.23.5Moisture Aborption (23° C J SW Rh)0.20.20.20.2ECETRICATION20.00.20.20.2Horthory (1)21.5m0.20.2Holly Voltage Arc Tackle (1) (1)21.5m0.20.2High Voltage Arc Tackle (1) (1)21.20.20.20.2High Voltage Arc Tackle (1) (1)220.20.20.2High Voltage Arc Tackle (1) (1)20.20.20.20.2High Voltage Arc Tackle (1) (1)20.2	Density	1.7	g/cm³	ASTM D792
Mold Shrinkage, xflow, 24 hrs <sup>(1)</sup> 0.3 – 0.8         %         XFM Degrate (1)         XFM Degrat	Moisture Absorption, (23°C/50% RH/24 hrs)	0.01	%	ASTM D570
Mold Shrinkage, flow, 24 hrs (1)0.13 - 0.18%%9.02 94Mold Shrinkage, xllow, 24 hrs (1)0.3 - 0.48%%9.02 94Wear Factor Washer3.310-10 in/S-min/fielberATM D3702 Modified: ManualDynamic CG0.442.ASTM D3702 Modified: ManualBatic CGF0.35-ASTM D3702 Modified: ManualDensity1.7glcm²50 183Moisture Absorption (23°C) 50% Hr)0.4%9.023.01Bufful Call1.7Code1.74.0Hot-Wire Indition (HW), PLCO (2)4.5m1.74.0High Amp Are Ightion (HW), PLCO (2)4.5m1.74.0High Amp Are Ightion (HW), PLCO (2)4.11.21.01.7Are Resistance, Tungsten (PLC)4.11.21.01.01.0Liyellow Gard Link5.01.71.01.01.0U. Yellow Card Link5.01.01.01.01.0U. Recognized, 404 O Flame Class Rating5.07.01.01.0U. Recognized, 404 O Flame Class Rating1.01.01.01.0U. Pring Temperature1.01.01.01.01.0Dring Temperature1.01.01.01.01.0Pring Temperature2.01.01.01.01.0Holder Leono La Temperature3.03.03.01.01.0Holder Leono La Temperature3.03.03.01.01.	Mold Shrinkage, flow, 24 hrs <sup>(3)</sup>	0.1 – 0.2	%	ASTM D955
Mold Shrinkage, xflow, 24 hrs <sup>(3)</sup> 03-04.84% 10-10 in/5-min/fit-bit m67-294 motified: ManualWear Factor Washer3410-10 in/5-min/fit-bit mASTM D3702 Modified: ManualDynamic COF0.443-10ASTM D3702 Modified: ManualStatic COF0.554-10Mol 20-20Desity0.72yera150-1183Moisture Absorption (23°C / 50% RH)0.72yera150-128Hoth Wire Ignition (HWI), PLC O <sup>(3)</sup> 44CodeU.746AHoth Wire Ignition (HWI), PLC O <sup>(3)</sup> 21.5mmU.746AHigh Amp Are Ignition (HWI), PLC O <sup>(3)</sup> 21.5mmU.746AHigh Voltage Are Track Rate (PLC) <sup>(3)</sup> 42.0W.CodeU.746AHoth CHARACTERITICs250-2780-1012828233ACCODEASTM D49SCU Yellow Card Link 2250-7780-101282823344U Yellow Card Link 2250-7780-101282823344U Yellow Card Link 2250-7780-101343867344U Yellow Card Link 2250-7780-101343867944U Yellow Card Link 3250-7780-101343867924Dipting Time and Link 3250-25334William 133334Winter Lone 333334Winter Lone 333334Winter Lone 3333344344 <t< th=""><th>Mold Shrinkage, xflow, 24 hrs <sup>(3)</sup></th><th>0.3 – 0.5</th><th>%</th><th>ASTM D955</th></t<>	Mold Shrinkage, xflow, 24 hrs <sup>(3)</sup>	0.3 – 0.5	%	ASTM D955
Wear Factor Washer3310-10 in/5-min/fi-thrATM D3702 Modified: ManualDynamic COF0.44-ATM D3702 Modified: ManualState COF0.35-ASTM D3702 Modified: ManualDensity17yearSO 183Moisture Absorption (3°C / 50% RH)17YearyearSO 183ECETRICAL (1)ECETRICAL (1)-FLC CodeU.746AHot-Wire Ignition (HWI), PLC 0°C)4PLC CodeU.746AHot Wire Ignition (HWI), PLC 0°C)4PLC CodeU.746AHigh Amp Arc Ignition (HAI), PLC 0°C)4PLC CodeU.746AArc Resistance, Tungsten (PLC)7PLC CodeU.746AHy Voltage Arc Track Rate (PLC) (2)4PLC CodeU.746AMu Yellow Card Link 2F207780-101282823PLC CodeASTM D495U Yellow Card Link 2F207780-1012828239U.94U Yellow Card Link 2F207780-1012828239U.94U Yellow Card Link 2PLO TSO TSO TSO TSO TSO TSO TSO TSO TSO TS	Mold Shrinkage, flow, 24 hrs (3)	0.13 - 0.18	%	ISO 294
Dynamic COF0.44ASTM D3702 Modified: ManualStatic COF0.35ASTM D3702 Modified: ManualDensity1.7Moisture Absorption (23°C / 50% RH)0.04ELECTION IIComparative Tracking Index (UL) (PLC) (2)4Cheb Wire Ignition (HM), PLC 0 (2)2.5High Amp Arc Ignition (HM), PLC 0 (2)4High Voltage Arc Track Rate (PLC) (2)4Arc Resistance, Tungsten (PLC)2Arc Resistance Track Rate (PLC) (2)4Use Induced Track Rate (PLC) (2)4Wellow Card Link 2Use Induced Link 2	Mold Shrinkage, xflow, 24 hrs (3)	0.3 - 0.48	%	ISO 294
Static COF0.35- ORTMO 30 MOTO MORTIFICATION MORTIFI	Wear Factor Washer	33	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified: Manual
Density17.17.18.18.18.18.18.Moisture Absorption (23°C / 50°R H)0.042 m18.18.18.ELECTRICAL.1**TUSA18.18.18.18.18.Comparative Tracking Index (UL) (PLC) (2)418.18.18.18.18.18.18.18.High Amp Arc Ignition (HMI), PLC 0 (2)21.5mm18.18.18.18.18.18.18.18.High Amp Arc Ignition (HMI), PLC 0 (2)21.5mm18. </th <th>Dynamic COF</th> <th>0.44</th> <th>-</th> <th>ASTM D3702 Modified: Manual</th>	Dynamic COF	0.44	-	ASTM D3702 Modified: Manual
Moisture Absorption (23°C / 50% RH)       0.04       %       5062         ELECTRICAL (¹)       V       V       V       Comparative Tracking Index (UL) {PLC} (²)       4       PLC Code       UL 746A       M         Hot Wire Ignition (HAV), PLC 0²       ≥1.5       mm       UL 746A       M       D       D       A       A       PLC Code       UL 746A       A       A       A       A       M       A       A       A       M       A <t< th=""><th>Static COF</th><th>0.35</th><th>-</th><th>ASTM D3702 Modified: Manual</th></t<>	Static COF	0.35	-	ASTM D3702 Modified: Manual
ELETRICAL (*)  Comparative Tracking Index (UL) {PLC} (*)  Hot Wire Ignition (HMI), PLC 0 (*)  High Amp Arc Ignition (HAI), PLC 0 (*)  High Amp Arc Ignition (HAI), PLC 0 (*)  Arc Resistance, Tungsten (PLC)  Arc Resistance, Tungsten (PLC)  Hot Villow Card Link  E207780-101282823	Density	1.7	g/cm³	ISO 1183
Comparative Tracking Index (UL) (PLC) (2)4PLC CodeUL 746AHot-Wire Ignition (HWI), PLC 0 (2)≥1.5mmUL 746AHigh Amp Arc Ignition (HAI), PLC 0 (2)≥1.5mmUL 746AHigh Voltage Arc Track Rate (PLC) (2)4PLC CodeUL 746AArc Resistance, Tungsten (PLC)7PLC CodeXSTM D495HAME CHARACTERISTICS (2)E207780-101282823-12UL Yellow Card Link£207780-101282823-2-3-3UL Yellow Card Link 2£207780-101343867-3-3-3UR Recognized, 94V-0 Flame Class Rating20.75mmUL 94Injury Temperature120 - 150C	Moisture Absorption (23°C / 50% RH)	0.04	%	ISO 62
Hot-Wire Ignition (HWI), PLC of 1221.5mmU. 746AHigh Amp Arc Ignition (HAI), PLC of 1221.5mmU. 746AHigh Voltage Arc Track Rate (PLC) 24PLC odeU. 746AArc Resistance, Tungsten (PLC)7PLC odeSXTM D495HAME CHARACTERISTICS (2)U. Yellow Card LinkE207780-10128282323U. Yellow Card Link 2E207780-10134282323U. Yellow Card Link 220.7580-10134286733U. Yellow Card Link 3233U. Yellow Card Link 4223U. Yellow Card Link 2223U. Yellow Card Link 3233U. Yellow Card Link 4233U. Yellow Card Link 4333U. Yellow Card Link 43<	ELECTRICAL (1)			
High Amp Arc Ignition (HAI), PLC 0 (2)≥1.5mmUL 746AHigh Voltage Arc Track Rate (PLC) (2)4PLC CodeUL 746AArc Resistance, Tungsten (PLC)7PLC CodeASTM D495FLAME CHARACTERISTICS (2)UL Yellow Card LinkE207780-101282823UL Yellow Card Link 2E207780-101343867UL Recognized, 94V-0 Flame Class Rating20.75mmUL 94INJECTION MOLDING (4)Urying Time4His-Portying Time4His-Melt Temperature315 - 320°C-Front - Zone 3 Temperature320 - 330°C-Middle - Zone 2 Temperature305 - 315°C-Mold Temperature140 - 165°C-Mold Temperature140 - 165CR-Mold Temperature140 - 165MPa	Comparative Tracking Index (UL) {PLC} (2)	4	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC} (2)4PLC CodeU. 746AArc Resistance, Tungsten {PLC}7PLC CodeASTM D495FLAME CHARACTERISTICS (2)TU Yellow Card LinkE207780-101282823UL Yellow Card Link 2E207780-101343867UL Recognized, 94V-0 Flame Class Rating20.75mmU.94INJECTION MOLDING (4)**+**Drying Temperature120 − 150**Projing Time4HrsMelt Temperature315 − 320****Front - Zone 3 Temperature30 − 345****Middle - Zone 2 Temperature305 − 315**** <th< td=""><th>Hot-Wire Ignition (HWI), PLC 0 (2)</th><td>≥1.5</td><td>mm</td><td>UL 746A</td></th<>	Hot-Wire Ignition (HWI), PLC 0 (2)	≥1.5	mm	UL 746A
Arc Resistance, Tungsten (PLC)7PLC CodeATM D495FLAME CHARACTERISTICS (2)Ut Yellow Card LinkE207780-101282823Ut Yellow Card Link 2E207780-101343867Ut Recognized, 94V-0 Flame Class Rating20.75mmUt 94INJECTION MOLDING (4)Drying Temperature120 - 150C-Projing Time4HrsMelt Temperature315 - 320C-Front - Zone 3 Temperature320 - 330C-Middle - Zone 2 Temperature320 - 330C-Rear - Zone 1 Temperature305 - 315C-Mold Temperature140 - 165C-Back Pressure0.2 - 0.3MPa-	High Amp Arc Ignition (HAI), PLC 0 (2)	≥1.5	mm	UL 746A
FLAME CHARACTERISTICS <sup>(2)</sup> Ut Yellow Card Link 2	High Voltage Arc Track Rate {PLC} (2)	4	PLC Code	UL 746A
UL Yellow Card Link 2  UL Necognized, 94V-0 Flame Class Rating  Diving Temperature  Mich Temperature  Mich Temperature  Middle-Zone 2 Temperature  Middle-Zone 2 Temperature  Mold Temperature	Arc Resistance, Tungsten {PLC}	7	PLC Code	ASTM D495
UL Yellow Card Link 2         E207780-101343867         -	FLAME CHARACTERISTICS (2)			
URecognized, 94V-0 Flame Class Rating \$2.75 mm Ul. 94  INIECTION MOLDING (4)  Drying Temperature 120 - 150 °C  Drying Time 44 Hrs  Melt Temperature 315 - 320 °C  Front - Zone 3 Temperature 320 - 330 °C  Middle - Zone 2 Temperature 305 - 315 °C  Rear - Zone 1 Temperature 140 - 165 °C  Mold Temperature 140 - 165 °C  Mold Temperature 140 - 165 °C  Meack Pressure 150 - 160 °C  Meack Pressure 160 160 °C  Meack Pressur	UL Yellow Card Link	E207780-101282823	-	
NL Recognized, 94V-0 Flame Class Rating  Portion MolDiNG (4)  Porting Temperature  Porting Time  Melt Temperature  Porting Temperature  Porting Temperature  Porting Time	UL Yellow Card Link 2	E207780-101343867		
Drying Temperature         120 − 150         ℃           Drying Time         4         Hrs           Melt Temperature         315 − 320         ℃           Front - Zone 3 Temperature         320 − 345         ℃           Middle - Zone 2 Temperature         320 − 330         ℃           Rear - Zone 1 Temperature         305 − 315         ℃           Mold Temperature         140 − 165         ℃           Back Pressure         0.2 − 0.3         MPa	UL Recognized, 94V-0 Flame Class Rating	≥0.75	mm	UL 94
Drying Temperature         120 − 150         ℃           Drying Time         4         Hrs           Melt Temperature         315 − 320         ℃           Front - Zone 3 Temperature         320 − 345         ℃           Middle - Zone 2 Temperature         320 − 330         ℃           Rear - Zone 1 Temperature         305 − 315         ℃           Mold Temperature         140 − 165         ℃           Back Pressure         0.2 − 0.3         MPa	INJECTION MOLDING (4)			
Drying Time         4         Hrs           Melt Temperature         315 – 320         °C           Front - Zone 3 Temperature         320 – 345         °C           Middle - Zone 2 Temperature         320 – 330         °C           Rear - Zone 1 Temperature         305 – 315         °C           Mold Temperature         140 – 165         °C           Back Pressure         0.2 – 0.3         MPa		120 – 150	°C	
Melt Temperature         315 – 320         °C           Front - Zone 3 Temperature         330 – 345         °C           Middle - Zone 2 Temperature         320 – 330         °C           Rear - Zone 1 Temperature         305 – 315         °C           Mold Temperature         140 – 165         °C           Back Pressure         0.2 – 0.3         MPa			Hrs	
Middle - Zone 2 Temperature         320 – 330         °C           Rear - Zone 1 Temperature         305 – 315         °C           Mold Temperature         140 – 165         °C           Back Pressure         0.2 – 0.3         MPa		315 – 320	°C	
Rear-Zone 1 Temperature         305 – 315         °C           Mold Temperature         140 – 165         °C           Back Pressure         0.2 – 0.3         MPa	Front - Zone 3 Temperature	330 – 345	°C	
Mold Temperature       140 – 165       °C         Back Pressure       0.2 – 0.3       MPa	Middle - Zone 2 Temperature	320 – 330	°C	
Back Pressure 0.2 – 0.3 MPa	Rear - Zone 1 Temperature	305 – 315	°C	
	Mold Temperature	140 – 165	°C	
Screw Speed         30 – 60         rpm	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) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.
- (3) 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.
- (4) 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**

Any sale by SABIC, its subsidiaries and affiliates (each a "seller"), is made exclusively under seller's standard conditions of sale (available upon request) unless agreed otherwise in writing and signed on behalf of the seller. While the information contained herein is given in good faith, SELLER MAKES NO WARRANTY, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY AND NONINFRINGEMENT OF INTELLECTUAL PROPERTY, NOR ASSUMES ANY LIABILITY, DIRECT OR INDIRECT, WITH RESPECT TO THE PERFORMANCE, SUITABILITY OR FITNESS FOR INTENDED USE OR PURPOSE OF THESE PRODUCTS IN ANY APPLICATION. Each customer must determine the suitability of seller materials for the customer's particular use through appropriate testing and analysis. No statement by seller concerning a possible use of any product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right.