

LNPTM LUBRICOMPTM COMPOUND PFI12R

PFL-4412 MR

DESCRIPTION

LNP LUBRICOMP PFI12R compound is based on Nylon 6 resin containing 10% glass fiber, 2% silicone. Added features of this grade include: Wear Resistant, Mold Release.

GENERAL INFORMATION	
Features	Wear resistant, Enhanced mold release, No PFAS intentionally added
Fillers	Glass Fiber, Silicone
Polymer Types	Polyamide 6 (Nylon 6)
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

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL⁽¹⁾			
Tensile Stress, break	105	MPa	ASTM D638
Tensile Strain, break	3.2	%	ASTM D638
Tensile Modulus, 50 mm/min	4950	MPa	ASTM D638
Flexural Stress	151	MPa	ASTM D790
Flexural Modulus	5250	MPa	ASTM D790
IMPACT⁽¹⁾			
Izod Impact, unnotched, 23°C	713	J/m	ASTM D4812
Izod Impact, notched, 23°C	53	J/m	ASTM D256
THERMAL⁽¹⁾			
HDT, 1.82 MPa, 3.2mm, unannealed	202	°C	ASTM D648
PHYSICAL⁽¹⁾			
Density	1.19	g/cm ³	ASTM D792
Mold Shrinkage, flow, 24 hrs ⁽²⁾	0.5	%	ASTM D955
INJECTION MOLDING⁽³⁾			
Drying Temperature	80	°C	
Drying Time	4	Hrs	
Maximum Moisture Content	0.15 – 0.25	%	
Melt Temperature	265 – 275	°C	
Front - Zone 3 Temperature	275 – 290	°C	
Middle - Zone 2 Temperature	265 – 275	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Rear - Zone 1 Temperature	250 – 260	°C	
Mold Temperature	80 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	30 – 60	rpm	