



LNP™ LUBRICOMP™ Compound Lexan_LF1510A

Americas: COMMERCIAL

LNP LUBRICOMP LEXAN_LF1510A compound is a 10% glass reinforced, 15% PTFE filled PC. Flame retardant and wear resistant. Tight tolerances.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	730	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	730	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	7	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	7	%	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1190	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	38600	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	51	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	10	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	172	cm-kgf	ASTM D 3763
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	132	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	126	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.4E-05	1/°C	ASTM E 831
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
Specific Gravity	1.36	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.2 - 0.3	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.35 - 0.5	%	SABIC Method
Melt Flow Rate, 300°C/1.2 kgf	8.1	g/10 min	ASTM D 1238
ELECTRICAL			
Hot Wire Ignition {PLC}	0	PLC Code	UL 746A



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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
ELECTRICAL			
High Ampere Arc Ign, surface {PLC}	0	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	3	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94V-0 Flame Class Rating (3)	1.49	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	48	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	290 - 310	°C
Nozzle Temperature	280 - 305	°C
Front - Zone 3 Temperature	290 - 310	°C
Middle - Zone 2 Temperature	275 - 300	°C
Rear - Zone 1 Temperature	265 - 290	°C
Mold Temperature	70 - 95	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm