



LNP™ LUBRILOY™ Compound Lexan_WR6300

Americas: COMMERCIAL

LNP LUBRILOY LEXAN_WR6300 compound is a wear resistant PC+SAN, with proprietary lubricant, for business equipment applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	620	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	164	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	980	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	258	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	69	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	16	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	614	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	136	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	117	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	133	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.06E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.19E-04	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	1.17	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Volume Rate, MVR at 300°C/2.16 kg	38	cm ³ /10 min	ISO 1133



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FLAME CHARACTERISTICS UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 270	°C
Nozzle Temperature	245 - 265	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	240 - 260	°C
Rear - Zone 1 Temperature	225 - 250	°C
Mold Temperature	50 - 80	°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