



LNP™ LUBRICOMP™ Compound KAL22

Americas: COMMERCIAL

Also known as: LNP™ LUBRICOMP™ Compound KAL-4022

Product reorder name: KAL22

LNP LUBRICOMP KAL22 is a compound based on Acetal Copolymer resin containing 10% PTFE, 10% Aramid Fiber. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	590	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	6.5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	7.4	%	ASTM D 638
Tensile Modulus, 5 mm/min	37000	kgf/cm ²	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	31500	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	57	MPa	ISO 527
Tensile Stress, break, 5 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6.3	%	ISO 527
Tensile Strain, break, 5 mm/min	7.4	%	ISO 527
Tensile Modulus, 1 mm/min	3450	MPa	ISO 527
Flexural Stress	77	MPa	ISO 178
Flexural Modulus, 2 mm/min	3070	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	52	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	5	cm-kgf/cm	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	32	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	162	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	132	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	87	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.46	-	ASTM D 792
Mold Shrinkage on Tensile Bar, flow (2) (5)	1.8 - 2.2	%	SABIC Method



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PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	2 - 4	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	2 - 4	%	ASTM D 955
Wear Factor Washer	8	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Wear Factor Ring	0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.23	-	ASTM D 3702 Modified
Static COF	0.16	-	ASTM D 3702 Modified
Density	1.45	g/cm ³	ISO 1183



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Melt Temperature	200 - 215	°C
Front - Zone 3 Temperature	210 - 220	°C
Middle - Zone 2 Temperature	195 - 205	°C
Rear - Zone 1 Temperature	175 - 190	°C
Mold Temperature	80 - 110	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	30 - 60	rpm