



LNP™ LUBRICOMP™ Compound Noryl_NF1520

Europe-Africa-Middle East: COMMERCIAL

LNP LUBRICOMP NORYL_NF1520 compound is a 20% glass reinforced, 15% PTFE. Wear resistant; 211F HDT @ 264 psi.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	750	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	750	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	4.2	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	1030	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	54100	kgf/cm ²	ASTM D 790
K-factor xE-10, PV=2000 psi-fpm vs Steel	73	-	SABIC Method
Coefficient of Friction on steel, Static	0.3	-	ASTM D 1894
Coefficient of Friction on steel, Kinetic	0.46	-	ASTM D 1894
IMPACT			
Izod Impact, unnotched, 23°C	36	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	7	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	102	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	96	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	105	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	99	°C	ASTM D 648
Relative Temp Index, Elec	50	°C	UL 746B
Relative Temp Index, Mech w/impact	50	°C	UL 746B
Relative Temp Index, Mech w/o impact	50	°C	UL 746B
PHYSICAL			
Specific Gravity	1.34	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.15 - 0.25	%	SABIC Method
Mold Shrinkage, xflow, 3.2 mm (5)	0.25 - 0.45	%	SABIC Method



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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 - 110	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	275 - 305	°C
Nozzle Temperature	275 - 305	°C
Front - Zone 3 Temperature	265 - 305	°C
Middle - Zone 2 Temperature	255 - 300	°C
Rear - Zone 1 Temperature	245 - 295	°C
Mold Temperature	70 - 100	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%
Vent Depth	0.038 - 0.051	mm