



LNP™ LUBRICOMP™ Compound Noryl_NWR5810

Americas: COMMERCIAL

LNP LUBRICOMP NORYL_NWR5810 compound is a 10% PTFE filled PPE+PS. High flow and good impact. Applications requiring wear resistance/lubricity. Electronics.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	400	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	380	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 50 mm/min	2.8	%	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	55	%	ASTM D 638
Tensile Modulus, 50 mm/min	22100	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	620	kgf/cm ²	ASTM D 790
Flexural Stress, yld, 2.6 mm/min, 100 mm span	580	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	21000	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	20300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	228	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	23	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	328	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	110	°C	ASTM D 1525
HDT, 0.45 MPa, 3.2 mm, unannealed	113	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	97	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	116	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	105	°C	ASTM D 648
CTE, -40°C to 60°C, flow	6.48E-05	1/°C	ASTM E 831
CTE, -40°C to 60°C, xflow	7.38E-05	1/°C	ASTM E 831
PHYSICAL			
Specific Gravity	1.11	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.55 - 0.7	%	SABIC Method



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PHYSICAL			
Mold Shrinkage, xflow, 3.2 mm (5)	0.45 - 0.7	%	SABIC Method
Melt Flow Rate, 260°C/5.0 kgf	5.5	g/10 min	ASTM D 1238



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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	95 - 100	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	8	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	260 - 290	°C
Nozzle Temperature	260 - 290	°C
Front - Zone 3 Temperature	250 - 290	°C
Middle - Zone 2 Temperature	240 - 280	°C
Rear - Zone 1 Temperature	225 - 275	°C
Mold Temperature	70 - 95	°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