



LNP™ LUBRICOMP™ Compound Noryl_SPN422L

Americas: COMMERCIAL

LNP LUBRICOMP NORYL_SPN422L compound is a wear resistant, fluorocarbon alloy, 235F (113C) HDT. UL94 HB rated. Check surface aesthetics prior to material specification.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	490	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	35	%	ASTM D 638
Flexural Stress, yld, 2.6 mm/min, 100 mm span	770	kgf/cm ²	ASTM D 790
Flexural Modulus, 2.6 mm/min, 100 mm span	23200	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, notched, 23°C	27	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -40°C	9	cm-kgf/cm	ASTM D 256
Gardner, 23°C	138	cm-kgf	ASTM D 3029
THERMAL			
HDT, 1.82 MPa, 6.4 mm, unannealed	112	°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	1.08	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Mold Shrinkage on Tensile Bar, xflow (2) (5)	0.5 - 0.7	%	SABIC Method
ELECTRICAL			
Arc Resistance, Tungsten {PLC}	6	PLC Code	ASTM D 495
Hot Wire Ignition {PLC}	2	PLC Code	UL 746A
High Voltage Arc Track Rate {PLC}	3	PLC Code	UL 746A
High Ampere Arc Ign, surface {PLC}	1	PLC Code	UL 746A
Comparative Tracking Index (UL) {PLC}	2	PLC Code	UL 746A
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.47	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	280 - 310	°C
Nozzle Temperature	280 - 310	°C
Front - Zone 3 Temperature	270 - 310	°C
Middle - Zone 2 Temperature	260 - 305	°C
Rear - Zone 1 Temperature	250 - 300	°C
Mold Temperature	75 - 105	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	20 - 100	rpm
Shot to Cylinder Size	30 - 70	%