

LNP™ LUBRICOMP™ COMPOUND KFI15

KFL-4415

REGION AMERICAS

DESCRIPTION

LNP LUBRICOMP KFI15 is a compound based on Acetal containing 25% Glass Fiber, 2% Silicone. Added feature of this grade is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20170913

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	112	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	102	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	1.9	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2	%	ASTM D 638
Tensile Modulus, 5 mm/min	9260	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	180	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	176	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	7850	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	118	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.4	%	ISO 527
Tensile Modulus, 1 mm/min	8710	MPa	ISO 527
Flexural Stress	172	MPa	ISO 178
Flexural Modulus, 2 mm/min	8010	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	537	J/m	ASTM D 4812
Izod Impact, notched, 23°C	76	J/m	ASTM D 256
Instrumented Impact Total Energy, 23°C	10	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	37	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	8	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	163	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	161	°C	ASTM D 648
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	163	°C	ISO 75/Bf

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	159	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.5	-	ASTM D 792
Density	1.56	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.18	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	1 – 3	%	ASTM D 955
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	

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