

## LNP\* Lubricomp\* Compound KP004AXC

Americas: COMMERCIAL

Also known as: KL-4540 D HP  
Product Reorder Name: KP004AXC

LNP LUBRICOMP\* KP004AXC is a compound based on Acetal Homopolymer resin containing PTFE, Silicone. Added features of this material include: Internally Lubricated.

### Property

TYPICAL PROPERTIES <sup>(1)</sup>			
MECHANICAL	Value	Unit	Standard
Tensile Stress, break	50	MPa	ASTM D 638
Tensile Strain, break	12.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	2200	MPa	ASTM D 638
Flexural Stress	76	MPa	ASTM D 790
Flexural Modulus	2410	MPa	ASTM D 790
Tensile Stress, break	45	MPa	ISO 527
Tensile Strain, break	10.5	%	ISO 527
Tensile Modulus, 1 mm/min	2600	MPa	ISO 527
Flexural Stress	76	MPa	ISO 178
Flexural Modulus	2800	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	448	J/m	ASTM D 4812
Izod Impact, notched, 23°C	48	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	5	J	ASTM D 3763
Multiaxial Impact	0	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	29	kJ/m <sup>2</sup>	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m <sup>2</sup>	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT, 0.45 MPa, 3.2 mm, unannealed	163	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	99	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	99	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.49	g/cm <sup>3</sup>	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.25	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	2.1	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	2.1	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	2.14	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	2.05	%	ISO 294
Wear Factor Washer	9	10 <sup>-10</sup> in <sup>5</sup> -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.25	-	ASTM D 3702 Modified
Static COF	0.15	-	ASTM D 3702 Modified
Density	1.49	g/cm <sup>3</sup>	ISO 1183

Source GMD, last updated:09/29/2004

### Processing

#### Parameter

Injection Molding	Value	Unit
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

Source GMD, last updated:09/29/2004

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

(2) Only typical data for selection purposes. Not to be used for part or tool design.

(3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.

(4) Internal measurements according to UL standards.

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