

LNP* Lubricomp* Compound KL004AXC

Americas: COMMERCIAL

Also known as: LNP* Lubricomp* Compound 404 D LEX BK8-229

Product reorder name: KL004AXC

LNP* Lubricomp* KL004AXC is a compound based on Acetal Homopolymer resin containing PTFE. Added features of this material include: Internally Lubricated. This grade was previously found under the LNP* Fulton* tradename.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	570	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	11.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	26000	kgf/cm ²	ASTM D 638
Flexural Stress	870	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	26700	kgf/cm ²	ASTM D 790
Tensile Stress, break, 5 mm/min	50	MPa	ISO 527
Tensile Strain, break, 5 mm/min	9.4	%	ISO 527
Tensile Modulus, 1 mm/min	2700	MPa	ISO 527
Flexural Stress	86	MPa	ISO 178
Flexural Modulus, 2 mm/min	2900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	57	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	4	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	71	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	39	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	4	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	95	°C	ASTM D 648
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	98	°C	ISO 75/Af
PHYSICAL			
Density	1.52	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.23	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs (5)	2 - 2.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	2 - 2.2	%	ASTM D 955

(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±176.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.

(5) Measurements made from laboratory test coupon. Actual shrinkage may vary outside of range due to differences in processing conditions, equipment, part geometry and tool design. It is recommended that mold shrinkage studies be performed with surrogate or legacy tooling prior to cutting tools for new molded article.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
PHYSICAL			
Mold Shrinkage, flow, 24 hrs (5)	2 - 2.19	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	2 - 2.19	%	ISO 294
Wear Factor Washer	12	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.22	-	ASTM D 3702 Modified
Static COF	0.09	-	ASTM D 3702 Modified
Density	1.52	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.37	%	ISO 62

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
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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