

# LNPTM LUBRICOMPTM COMPOUND OCL36

OCL-4036 REGION ASIA

#### DESCRIPTION

LNP LUBRICOMP\* OCL36 is a compound based on PPS - Linear resin containing 30% Carbon Fiber, 15% PTFE. Added features of this material include: Electrically Conductive, Wear Resistant.

### TYPICAL PROPERTY VALUES

MCCHANICALTensile Stress, break168MPaASTM D 638Tensile Sdutain, break1.4%ASTM D 638Tensile Strain, break12110MPaASTM D 638Flexural Stress259MPaASTM D 638Flexural Modulus21100MPaASTM D 790Flexural Modulus21100MPaASTM D 790Tensile Stress, break1.1%605 27Tensile Stress, break1.1%605 27Tensile Stress, break1.1%605 27Tensile Modulus, 1 mm/min30680MPa150 187Tensile Modulus, 1 mm/min20200MPa150 187Flexural Stress21200MPa150 187Flexural Stress21200MPa150 187Indext, unotched, 23°C443J/mASTM D 4812Izod Impact, notched, 23°C58J/mASTM D 566Instrumented Impact Energy @peak, 23°C31K/m²150 180/10Izod Impact, notched 80°10'4 +23°C31K/m²150 180/10Izod Impact, notched 80°10'4 +23°C267°CASTM D 576HTFT, 1.82 MPa, 3.2mm, unannealed267°CASTM D 555Mold Shrinkage, flow, 24 hrs0.41-0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.41-0.1%ASTM D 570 Modified: ManualMold Shrinkage, flow, 24 hrs0.41-0.1%0.294Mold Shrinkage, flow, 24 hrs0.41-0.1%0.294Mold Shrinkage, flow, 24 hrs0.41-0.1 </th <th>PROPERTIES</th> <th>TYPICAL VALUES</th> <th>UNITS</th> <th>TEST METHODS</th>	PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Teslie Srain, break1.4%ASIM D 638Tensile Modulus, 50 mm/min21510MPaASTM D 638Flexural Stress259MPaASTM D 790Heural Modulus21110MPaASTM D 790Tensile Stress, break166MPa150 527Tensile Strain, break1.1%S0 527Tensile Strain, break1.1%S0 527Tensile Modulus, 1 mm/min30680MPa150 527Tensile Modulus, 1 mm/min21200MPa150 78Flexural Modulus21200MPa150 78Flexural Modulus21200MPaS150 78Idot Impact, notched, 23°C443J/mASTM D 4812Idot Impact, notched, 23°C15J/mASTM D 256Instrumented Impact Energy@peak, 23°C31J/m?S10 104Idot Impact, unotched 80°10°4 + 23°C31J/m?S10 104Idot Impact, notched 80°10°4 + 23°C31J/m?S10 101Idot Impact, unotched 80°10°4 + 23°C32CS0 75/HIdot Impact, unotched 80°10°4 + 23°C32S10S10 104Idot Impact, notched 80°10°4 + 23°C31S10S10 104Idot Impact, notched 80°10°4 + 23°C31S10S10 104Idot Impact, notched 80°10°4 + 23°C32S10S10 104Idot Impact, Instrumented Impact ImpactS10 20S10 104Idot Impact, Instrumented Impact ImpactS10 20S10 104Idot Impact, Impact ImpactS10 20S10 20<	MECHANICAL			
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Hexaral Stress259MPaASTM D 790Hexural Modulus21110MPaASTM D 790Tensile Stress, Dreak166MPaBS 527Tensile Strain, Dreak30680MPaBS 527Tensile Modulus, 1mm/min30680MPaBS 527Fexural Stress262MPaBS 178Hexural Modulus21200MPaBS 178Instrumentched, 23°C443J/manASTM D 482Izod Impact, nontched, 23°C15J/manASTM D 482Izod Impact, nontched, 23°C15JSO 6003Instrumented Impact Bergy @ peak, 24°C16J/manMS D 368Izod Impact, nontched, 23°C31M/m2SO 180/10Izod Impact, nontched, 23°C22JSO 6003Instrumented Impact Bergy @ peak, 24°C16JSO 180/10Izod Impact, nontched 80°10°4 + 23°C31M/m2SO 180/10Izod Impact, nontched 80°10°4 + 23°C263°CSO 180/10Izod Impact, nontched 80°10°4 + 23°C263°CSO 180/10Izod Impact, nontched 80°10°4 + 23°C360°CSO 180/10Izod Impact, Nontched 80°10°4 + 23°C363°CSO 180/10Izod Impact, Nontched 80°10°4 + 23°C363°CSO 180/10Izot Impact, Nontched 80°10°4 + 23°C363°CSO 180/10Izot Impact, Nontched 80°10°4 + 23°C363°CSO 180/10Izot Impact, Nontched 80°10°4 + 23°C363°CSO 180/10Ido Ido Infrindeg,	Tensile Strain, break	1.4	%	ASTM D 638
Hexural Modulus21110MPaASTM D 790Tensile Strain, break166MPa180 527Tensile Strain, break1.1%180 527Tensile Modulus, 1 mm/min30680MPa180 527Tensile Modulus, 1 mm/min2620MPa150 178Flexural Stress262MPa150 178Flexural Modulus21200MPa50 178Instrumented Inpact, unnotched, 23°C4431/mASTM D 4812Izod Impact, unnotched, 23°C581/mASTM D 266Instrumented Impact Energy@peak, 23°C151MD 3763Multiaxial Impact21S0 6603Inpact, notched 80°10'4 +23°C31kl/m²IS0 180/10Izod Impact, notched 80°10'4 +23°C66kl/m²IS0 180/10Izod Impact, notched 80°10'4 +23°C263°CASTM D 648HDT 1.42 RMP, 3.2mm, unanneled263°CASTM D 648HDT 1.42 RMP, 3.2mm, unanneled1.52glcm³ASTM D 955Mold Shrinkage, flow, 24 hrs0.40-0.1%ASTM D 952Mold Shrinkage, flow, 24 hrs0.30-0.4%ISO 294Mold Shrinkage, flow, 24 hrs0.36-0.4%ISO 294Mold Shrinkage, flow, 24 hrs0.	Tensile Modulus, 50 mm/min	21510	MPa	ASTM D 638
Tensile Stress, break166MPaS0 527Tensile Strain, break1.1%S0 527Tensile Modulus, 1 mm/min30680MPaS0 527Flexural Stress2620MPaS0 178Flexural Modulus21000MPaS0 178MRACT12000MPaS0 178Ecal Impact, unotched, 23°C433J/mASTM 0 4812Izod Impact, unotched, 23°C58J/mASTM 0 256Instrumented Impact Energy@peak, 23°C15JS0 180/10Izod Impact, notched 80°10°4 +23°C61kl/m²S0 180/10Izod Impact, notched 80°10°4 +23°C61kl/m²S0 180/10Izod Impact, notched 80°10°4 +23°C62S0 180/10S0 180/10Izod Impact, notched 80°10°4 +23°C62kl/m²S0 180/10Izod Impact, notched 80°10°4 +23°C62S0 180/10S0 180/10Izod Impact, notched 80°10°4 +23°C62%CASTM 0 576HTERMAL267%CASTM 0 576HDT/At, 1.8 MPa Flatw 80°10°4 sp=64mm263%CS0 75/AfPHYSICAJJS1M 0 575Mold Shrinkage, flow, 24 hrs0.40-0.1%S0 529Mold Shrinkage, flow, 24 hrs0.30-0.4%S0 294Mold Shrinkage, flow, 24 hrs0.36-0.4%S0 294Mold Shrinkage, flow, 24 hrs0.36-0.4%S1M 0 3702 Modified: ManualDynamic COF0.34-ASTM 0 3702 Modified: ManualDynamic COF0.34-S0 1	Flexural Stress	259	MPa	ASTM D 790
Tensile Strain, break1.1%S0 527Tensile Modulus, 1 mm/min30680MPaS0 527Flexural Stress262MPaS0 178Flexural Modulus21000MPaS0 178Internation Modulus21000MPaS0 178Internation Modulus21000MPaS0 178Internation Modulus30178S0 178Internation Modulus30100Man Astm D 4812Internation Model, 23°C50JAstm D 4812Instrumented Impact Energy@peak, 23°C51JS0 1600Instrumented Impact Strengy@peak, 23°C51JS0 6603Instrumented Impact Strengy@peak, 23°C31kJ/m2S0 180/10Muttaxial Impact2JS0 180/10Instrumented String*4:23°C31kJ/m2S0 180/10Instrumented Strengy@peak, 23°C31kJ/m2S0 180/10Instrumented Strengy@peak, 23°C31kJ/m2S0 180/10Instrumented Impact Energy@peak, 23°C31kJ/m2S0 180/10Instrumented Impact Strengy@peak, 23°C31S0 180S0 180Instrumented Impact Strengy@peak, 23°C31S0 180S0 180Instrumented Impact Strengy@p	Flexural Modulus	21110	MPa	ASTM D 790
Tensile Modulus, 1 mm/min30680MPaIso 527Hexural Stress262MPaIso 178Hexural Modulus21200MPaIso 178Imman1200MPaIso 178Imman1200MPaSo 178Imman1200MPaSo 178Imman1200MPaSo 178Imman1200MPaSo 178Imman1200MPaSo 178Imman1200MPaSo 178Imman1200MPaSo 178Imman12001200ASTM 04812Imman23°C1200ASTM 04812Imman23°C12001200Multixial Impact2431MinmanImman2631MinmanIso 1801/UImman2631MinmanIso 1801/UImman262747So 1801/UImman262727So 1801/UImman2627272000Imman267272000So 1801/UImman26726720002007/SImman26726720002007/SImman26726720002007/SImman26726720002007/SImman26727272000Imman26727272000Imman26727272000Imman2727272000<	Tensile Stress, break	166	MPa	ISO 527
Flexural Stress262MPa50178Flexural Modulus21200MPa50178IMPACTImmodule AttractSTM 0.4812Izod Impact, unotched, 23°C443J/mASTM 0.4812Izod Impact, notched, 23°C58J/mASTM 0.256Instrumented Impact Energy@peak, 23°C58J/mS018010Izod Impact, unotched 80°10°4 + 23°C31J/m2S018010Izod Impact, unotched 80°10°4 + 23°C31J/m2S018010Izod Impact, unotched 80°10°4 + 23°C61J/m2S018010Izod Impact, unotched 80°10°4 + 23°C62J/m2S018010Izod Impact, unotched 80°10°4 + 23°C62J/m2S018010Izod Impact, unotched 80°10°4 + 23°C63J/m2S018010Izod Impact, unotched 80°10°4 + 23°C63J/m2S018010Izod Impact, unotched 80°10°4 + 23°C63S018010S018010Izod Impact, unotched 80°10°4 + 23°C63S018010S018010Izod Impact, unotched 80°10°4 + 23°C63S018010S018010Izod Impact, unotched 80°10°4 + 23°C63S018010S0180100Izod Impact, unotched 80°10°4 + 23°C63S0180100S0180100Izod Impact, Index Soften Softe	Tensile Strain, break	1.1	%	ISO 527
Flexural Modulus21200MPa50 178IMPACTImpact, unnotched, 23°C443J/mASTM D 4812Izod Impact, notched, 23°C58J/mASTM D 256Instrumented Impact Energy @ peak, 23°C15JASTM D 3763Multiaxial Impact2JS0 603Izod Impact, notched 80°10°4 +23°C31k/m²ISO 180/10Izod Impact, notched 80°10°4 +23°C3161S0 180/10Izod Impact, notched 80°10°4 +23°C3161S0 180/10Izod Impact, notched 80°10°4 +23°C3161S0 180/10Izod Impact, notched 80°10°4 +23°C3131S0 180/10Izod Impact, notched 80°10°4 +23°C313231Ipot Impact, notched 80°10°4 +23°C313231Ipot Impact, notched 80°10°4 +23°C313231Ipot Impact, notched 80°10°4	Tensile Modulus, 1 mm/min	30680	MPa	ISO 527
IMPACTIzod Impact, unnotched, 23°C443J/mASTM 0 4812Izod Impact, notched, 23°C58J/mASTM 0 256Instrumented Impact Energy@peak, 23°C15JASTM 0 3763Multiaxial Impact2JISO 6003Izod Impact, unnotched 80°10°4 +23°C31kl/m²ISO 180/1UIzod Impact, notched 80°10°4 +23°C6kl/m²ISO 180/1UIzod Impact, notched 80°10°4 +23°C6SISO 180/1UItot Impact, notched 80°10°4 +23°C6SISO 180/1UItot Impact, notched 80°10°4 +23°C152g/cm³SIsO 180Ibol Itot Impact, notched 80°10°4 +23°C0.04 - 0.1%IsO 294IsO 180Mold Shrinkage, flow, 24 hrs0.04 - 0.1%IsO 294IsO 180IsO 180Mold Shrinkage, flow, 24 hrs0.36 - 0.4%IsO 294IsO 180IsO	Flexural Stress	262	MPa	ISO 178
Izod Impact, unnotched, 23°C443J/mASTM D 4812Izod Impact, notched, 23°C58J/mASTM D 256Instrumented Impact Energy@peak, 23°C15JASTM D 3763Multiaxial Impact2JISO 6603Izod Impact, unnotched 80°10°4 + 23°C31KJ/m²ISO 180/10Izod Impact, notched 80°10°4 + 23°C6KJ/m²ISO 180/10Izod Impact, notched 80°10°4 + 23°C6KJ/m²ISO 180/10Izod Impact, notched 80°10°4 + 23°C6KJ/m²ISO 180/10IteRMALSO 180/10ISO 180/10THERMALSO 180/10ISO 180/10Physical152°CSO TS/AFMold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.04-0.1%ISO 294Mold Shrinkage, flow, 24 hrs0.36-0.4%ISO 294Mold Shrinkage, flow, 24 hrs0.36-0.4%ISO 294Mold Shrinkage, flow, 24 hrs0.39.ASTM D 3702 Modified: ManualDepartic COF0.34.ASTM D 3702 Modified: ManualDensity1.52g/cm³ISO 1183Mo	Flexural Modulus	21200	MPa	ISO 178
Izod Impact, notched, 23°C58J/mASTM D 256Instrumented Impact Energy @ peak, 23°C15JASTM D 3763Multiaxial Impact2JISO 6603Izod Impact, unnotched 80°10°4 + 23°C31kJ/m²ISO 180/1UIzod Impact, notched 80°10°4 + 23°C6kJ/m²ISO 180/1UIzod Impact, notched 80°10°4 + 23°C6kJ/m²ISO 180/1AHERMAL267°CASTM D 648HDT J. 82 MPa, 3.2mm, unannealed263°CISO 75/AfHDT JAf, 1.8 MPa Flatw 80°10°4 sp=64mm263°CISO 75/AfPHYSICALg/cm³ASTM D 792Mold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.3 - 0.4%ISO 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%ISO 1302 Modified: ManualDynamic COF0.39-ASTM D 3702 Modified: ManualEnsity0.34-SO 183ISO 183Density1.52g/cm³ISO 1183Density0.36%ISO 183Hotser Absorption (23°C / 50% RH)0.03%ISO 204	IMPACT			
Instrumented Impact Energy@peak, 23°C15JASTM D 3763Multiaxial Impact2JSo 6603Izod Impact, unotched 80°10°4 +23°C31kJ/m²So 180/10Izod Impact, notched 80°10°4 +23°C6kJ/m²So 180/10HERMAL267°CASTM D 648HDT J. 82 MPa, 3.2mm, unanealed267°CSo TS /AfHDT/Af, 1.8 MPa Flatw 80°10°4 sp=64mm263°CSo TS /AfPHSICALJ9/cm³ASTM D 792Mold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.34 - 0.1%So 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%So 10 3702 Modified: ManualDynamic COF0.39-ASTM D 3702 Modified: ManualStatic COF0.34.So 1183Density1.52g/cm³So 1183Density0.36%So 1813	Izod Impact, unnotched, 23°C	443	J/m	ASTM D 4812
Multiaxial Impact2JSO 6603Izod Impact, unnotched 80*10*4 +23°C31kl/m²SO 180/10Izod Impact, notched 80*10*4 +23°C6kl/m²SO 180/1ATHERMALTSTM D 648HDT, 1.82 MPa, 3.2mm, unannealed267°C AASTM D 648HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm263°C ASTM D 5/AfPHYSICALTTTDensity1.52g/cm³ASTM D 792Mold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.04 - 0.1%SO 294Mold Shrinkage, flow, 24 hrs0.04 - 0.1%SO 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%SO 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualDynamic COF0.39-ASTM D 3702 Modified: ManualStatic COF0.34.20MO13STM D 3702 Modified: ManualDensity0.03%SO 183SO 294Moter Absorption (23°C / 50% RH)0.03%SO 294	Izod Impact, notched, 23°C	58	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C31kl/m²ISO 180/14Izod Impact, notched 80*10*4 +23°C6kl/m²ISO 180/1ATHERMALHDT, 1.82 MPa, 3.2mm, unannealed267°CASTM D 648HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm267°CASTM D 648PHYSICALDensity0.04 - 0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.04 - 0.1%So 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%So 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%So 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%ASTM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%So 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%So 180 702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%So 19702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%So 19702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%So 19702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%So 19702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%So 19702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%So 1183Mold Shrinkage, flow, 24 hrs0.03%So 1802Mold Shrinkage, flow, 24 hrs%%So 1803 <th>Instrumented Impact Energy @ peak, 23°C</th> <th>15</th> <th>1</th> <th>ASTM D 3763</th>	Instrumented Impact Energy @ peak, 23°C	15	1	ASTM D 3763
Izod Inpact, notched 80°10°4 +23°C6kl /m²ISO 180/1ATHERMALHDT, 1.82 MPa, 3.2mm, unannealed267°CASTM D 648HDT/Af, 1.8 MPa Flatw 80°10°4 sp=64mm263°CSO 75/AfPHYSICALDensity1.52g/cm³ASTM D 792Mold Shrinkage, flow, 24 hrs0.04 - 0.1% and p 955Mold Shrinkage, flow, 24 hrs0.3-0.4% and p 955Mold Shrinkage, flow, 24 hrs0.04 - 0.1% and p 955Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 955Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 955Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 955Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and p 950Mold Shrinkage, flow, 24 hrs0.36 - 0.4% and	Multiaxial Impact	2	]	ISO 6603
THERMAL 267 °C ASTM D 648   HDT, 1.82 MPa, 3.2mm, unannealed 263 °C Iso 75/Af   PHTYSICAL 9/cm³ ASTM D 792   Density 1.52 g/cm³ ASTM D 955   Mold Shrinkage, flow, 24 hrs 0.04 - 0.1 % ASTM D 955   Mold Shrinkage, flow, 24 hrs 0.3 - 0.4 % ASTM D 955   Mold Shrinkage, flow, 24 hrs 0.36 - 0.1 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 294   Mold Shrinkage, flow, 24 hrs 0.36 - 0.4 % So 10.4   Dynamic COF 0.39 . <td>Izod Impact, unnotched 80*10*4 +23°C</td> <td>31</td> <td>kJ/m²</td> <td>ISO 180/1U</td>	Izod Impact, unnotched 80*10*4 +23°C	31	kJ/m²	ISO 180/1U
HDT, 1.82 MPa, 3.2mm, unannealed267°CASTM D 648HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm263°CISO 75/AfPHYSICALJS2g/cm³ASTM D 792Density1.52g/cm³ASTM D 955Mold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, flow, 24 hrs0.3-0.4%S0 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%ISO 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%ASTM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.39-STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.34-STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.34-STM D 3702 Modified: ManualDynamic COF0.34.STM D 3702 Modified: ManualDensity0.36%Sto 1183Mold Shrinkage, flow, 24 / 50% RH)0.36%Mold Shrinkage, flow, 24 / 50% RH).Sto 29Mold Shrinkage, flow,	Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm263°CISO 75/AfPHYSICALJS2g/cm³ASTM D 792Density1.52g/cm³ASTM D 792Mold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, sflow, 24 hrs0.3-0.4%S0 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%ISO 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%S0 294Mold Shrinkage, sflow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.36 - 0.4%STM D 3702 Modified: ManualMold Shrinkage, sflow, 24 hrs0.39-ASTM D 3702 Modified: ManualMold Shrinkage, flow, 24 hrs0.39-STM D 3702 Modified: ManualMold Shrinkage, sflow, 24 hrs0.39-STM D 3702 Modified: ManualMold Shrinkage, sflow, 24 hrs0.34-StM D 3702 Modified: ManualMold Shrinkage, sflow, 24 hrs </td <td>THERMAL</td> <td></td> <td></td> <td></td>	THERMAL			
PHYSICALDensity1.52g/cm³ASTM D 792Mold Shrinkage, flow, 24 hrs0.04 - 0.1%ASTM D 955Mold Shrinkage, xflow, 24 hrs0.3 - 0.4%SO 294Mold Shrinkage, flow, 24 hrs0.36 - 0.4%SO 294Mold Shrinkage, xflow, 24 hrs0.37 - 0.4%SO 294Dynamic COF0.39-1.52SO 1183SO 1183Density0.03%%SO 1183Mold Shrinkage, flow, 23°C / 50% RH)0.03%SO 128Mold Shrinkage, flow, 23°C / 50% RH0.93%SO 128Mold Shrinkage, flow, 24°C / 50% RH0.93%SO 128Mold Shrinkage, flow, 24°C / 50% RH	HDT, 1.82 MPa, 3.2mm, unannealed	267	°C	ASTM D 648
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Mold Shrinkage, xflow, 24 hrs0.36 - 0.4%ISO 294Wear Factor Washer1910^-10 in^5-min/ft-lb-hrASTM D 3702 Modified: ManualDynamic COF0.39-ASTM D 3702 Modified: ManualStatic COF0.34-ASTM D 3702 Modified: ManualDensity1.52g/cm³ISO 1183Moisture Absorption (23°C / 50% RH)0.03%ISO 294	Mold Shrinkage, xflow, 24 hrs	0.3 - 0.4	%	ASTM D 955
Wear Factor Washer1910^-10 in^5-min/ft-lb-hrASTM D 3702 Modified: ManualDynamic COF0.39-ASTM D 3702 Modified: ManualStatic COF0.34-ASTM D 3702 Modified: ManualDensity1.52g/cm³ISO 1183Moisture Absorption (23°C / 50% RH)0.03%ISO 62	Mold Shrinkage, flow, 24 hrs	0.04 - 0.1	%	ISO 294
Dynamic COF 0.39 ASTM D 3702 Modified: Manual   Static COF 0.34 ASTM D 3702 Modified: Manual   Density 1.52 g/cm³ ISO 1183   Moisture Absorption (23°C / 50% RH) 0.03 % ISO 62	Mold Shrinkage, xflow, 24 hrs	0.36 - 0.4	%	ISO 294
Static COF 0.34 - ASTM D 3702 Modified: Manual   Density 1.52 g/cm³ ISO 1183   Moisture Absorption (23°C / 50% RH) 0.03 % ISO 62	Wear Factor Washer	19	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Density 1.52 g/cm <sup>3</sup> ISO 1183   Moisture Absorption (23°C / 50% RH) 0.03 % ISO 62	Dynamic COF	0.39	-	ASTM D 3702 Modified: Manual
Moisture Absorption (23°C / 50% RH) 0.03 % ISO 62	Static COF	0.34	-	ASTM D 3702 Modified: Manual
	Density	1.52	g/cm <sup>3</sup>	ISO 1183
	Moisture Absorption (23°C / 50% RH)	0.03	%	ISO 62
INJECTION MOLDING	INJECTION MOLDING			
<b>Drying Temperature</b> 120 – 150 °C	Drying Temperature	120 – 150	°C	

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## CHEMISTRY THAT MATTERS

Revision 20180906



PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Time	4	hrs	
Melt Temperature	315 – 320	°C	
Front - Zone 3 Temperature	330 - 345	°C	
Middle - Zone 2 Temperature	320 - 330	°C	
Rear - Zone 1 Temperature	305 - 315	°C	
Mold Temperature	140 – 165	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 - 60	rpm	

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