

LNPTM LUBRICOMPTM COMPOUND 2FL24

FP-EFL-4024

DESCRIPTION

LNPTM LUBRICOMPTM 2FL24 is a compound based on ETFE resin containing 20% Glass Fiber, 10% PTFE. Added feature of this grade is Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	69	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	6.5	%	ASTM D 638
Tensile Modulus, 5 mm/min	6440	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	4760	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	67	MPa	ISO 527
Tensile Strain, break, 5 mm/min	6.2	%	ISO 527
Tensile Modulus, 1 mm/min	5000	MPa	ISO 527
Flexural Stress	89	MPa	ISO 178
Flexural Modulus, 2 mm/min	4980	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1340	J/m	ASTM D 4812
Izod Impact, notched, 23°C	488	J/m	ASTM D 256
Multiaxial Impact	8	J	ISO 6603
Instrumented Impact Total Energy, 23°C	20	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	92	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	45	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	251	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	198	°C	ASTM D 648
CTE, -30°C to 30°C, flow	2.4E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	9.4E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	239	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	160	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.8	-	ASTM D 792
Density	1.8	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.6 – 0.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	1 – 3	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.01	%	ISO 62
INJECTION MOLDING			
Drying Temperature	120 – 150	°C	
Drying Time	4	hrs	
Melt Temperature	315	°C	
Front - Zone 3 Temperature	325 – 340	°C	

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Middle - Zone 2 Temperature	300 – 325	°C	
Rear - Zone 1 Temperature	280 – 300	°C	
Mold Temperature	90 – 120	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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