



## LNP™ STAT-KON™ Compound KEL32

### Europe-Africa-Middle East: COMMERCIAL

LNP LUBRICOMP KEL32 is a compound based on Acetal Copolymer resin containing Carbon Fiber, PTFE. Added features include: Electrically Conductive, Internally Lubricated.

| TYPICAL PROPERTIES <sup>1</sup>       | TYPICAL VALUE   | Unit              | Standard     |
|---------------------------------------|-----------------|-------------------|--------------|
| <b>MECHANICAL</b>                     |                 |                   |              |
| Tensile Stress, break, 5 mm/min       | 51              | MPa               | ISO 527      |
| Tensile Strain, break, 5 mm/min       | 4               | %                 | ISO 527      |
| Tensile Modulus, 1 mm/min             | 8400            | MPa               | ISO 527      |
| Flexural Stress, yield, 2 mm/min      | 80              | MPa               | ISO 178      |
| Flexural Stress, break, 2 mm/min      | 62              | MPa               | ISO 178      |
| Flexural Strain, break, 2 mm/min      | 6.4             | %                 | ISO 178      |
| Flexural Modulus, 2 mm/min            | 6000            | MPa               | ISO 178      |
| <b>IMPACT</b>                         |                 |                   |              |
| Izod Impact, unnotched 80*10*4 +23°C  | 15              | kJ/m <sup>2</sup> | ISO 180/1U   |
| Izod Impact, notched 80*10*4 +23°C    | 5               | kJ/m <sup>2</sup> | ISO 180/1A   |
| <b>THERMAL</b>                        |                 |                   |              |
| HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm | 141             | °C                | ISO 75/Af    |
| <b>PHYSICAL</b>                       |                 |                   |              |
| Mold Shrinkage, flow (5)              | 0.32            | %                 | SABIC Method |
| Density                               | 1.51            | g/cm <sup>3</sup> | ISO 1183     |
| Water Absorption, 23°C/24hrs          | 0.31            | %                 | ISO 62-1     |
| <b>ELECTRICAL</b>                     |                 |                   |              |
| Surface Resistivity                   | 1.E+02 - 1.E+04 | Ohm               | ASTM D 257   |



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| PROCESSING PARAMETERS       | TYPICAL VALUE | Unit |
|-----------------------------|---------------|------|
| <b>Injection Molding</b>    |               |      |
| 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  |