

LNP* Lubricomp* Compound OCL-4536

Asia Pacific: COMMERCIAL

LNP* Lubricomp* OCL-4536 is a compound based on PPS - Branched resin containing PTFE, Carbon Fiber, Silicone. Added features of this material include:
Internally Lubricated, Electrically Conductive.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
MECHANICAL			
Tensile Stress, yield	1300	kgf/cm ²	ASTM D 638
Tensile Stress, break	1210	kgf/cm ²	ASTM D 638
Tensile Strain, yield	0.9	%	ASTM D 638
Tensile Strain, break	1.6	%	ASTM D 638
Tensile Modulus, 50 mm/min	189800	kgf/cm ²	ASTM D 638
Flexural Stress	2340	kgf/cm ²	ASTM D 790
Flexural Modulus	205200	kgf/cm ²	ASTM D 790
Tensile Stress, yield	113	MPa	ISO 527
Tensile Stress, break	113	MPa	ISO 527
Tensile Strain, yield	0.7	%	ISO 527
Tensile Strain, break	0.7	%	ISO 527
Tensile Modulus, 1 mm/min	19880	MPa	ISO 527
Flexural Stress	176	MPa	ISO 178
Flexural Modulus	19000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	32	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	3	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	64	cm-kgf	ASTM D 3763
Multiaxial Impact	15	cm-kgf	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	13	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	3	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	273	°C	ASTM D 648

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	UNIT	STANDARD
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	258	°C	ASTM D 648
CTE, -40°C to 40°C, flow	3.6E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	7.2E-06	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	3.6E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.E-06	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	272	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	248	°C	ISO 75/Af
PHYSICAL			
Density	1.49	g/cm ³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs		%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.7	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.15	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.66	%	ISO 294
Wear Factor Washer	15	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.36	-	ASTM D 3702 Modified
Static COF	0.3	-	ASTM D 3702 Modified
Density	1.53	g/cm ³	ISO 1183

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PROCESSING PARAMETERS	TYPICAL VALUE	UNIT
Injection Molding		
Drying Temperature	120 - 150	°C
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