LNP™ LUBRICOMP™ Compound ECL36XXQ

Americas: COMMERCIAL

Also known as: LNP™ LUBRICOMP™ Compound ECL36XXQ
Product reorder name: ECL36XXQ

LNP™ LUBRICOMP™ ECL36XXQ is a compound based on Polyetherimide containing 30% Carbon Fiber, 15% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTIES[1]	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	2260	kgf/cm²	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	0.9	%	ASTM D 638
Tensile Modulus, 5 mm/min	335000	kgf/cm²	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	3300	kgf/cm²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	268100	kgf/cm²	ASTM D 790
Tensile Stress, break, 5 mm/min	226	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1	%	ISO 527
Tensile Modulus, 1 mm/min	30420	MPa	ISO 527
IMPACT			
Izod Impact, unnotched, 23°C	42	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	7	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	119	cm-kgf	ASTM D 3763
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	208	°C	ASTM D 648
PHYSICAL			
Specific Gravity	1.39	-	ASTM D 792
Density	1.39	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.01 - 0.05	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.1 - 0.4	%	ASTM D 955
Wear Factor Washer	22	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.39	-	ASTM D 3702 Modified
Static COF	0.42	-	ASTM D 3702 Modified
ELECTRICAL			
Surface Resistivity	1.E+02 - 1.E+04	Ohm	ASTM D 257

(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°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.
(6) Needs hard coat to consistently pass 60 sec Vertical Burn.

Source GMD, last updated:

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	120 - 150	°C
Drying Time	4 - 6	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	360 - 365	°C
Front - Zone 3 Temperature	365 - 375	°C
Middle - Zone 2 Temperature	355 - 365	°C
Rear - Zone 1 Temperature	345 - 355	°C
Mold Temperature	120 - 150	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	60 - 100	rpm

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