

LNP* Lubricomp* Compound OFL36XXC

Americas: COMMERCIAL

LNP* Lubricomp* OFL36XXC is a compound based on Linear Polyphenylene Sulfide (PPS) containing Glass Fiber and PTFE. Characteristics of this grade are: Internally Lubricated.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	1260	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	1260	kgf/cm ²	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	1.3	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	1.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	130500	kgf/cm ²	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	1810	kgf/cm ²	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	1810	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	118200	kgf/cm ²	ASTM D 790
Tensile Stress, yield, 5 mm/min	121	MPa	ISO 527
Tensile Stress, break, 5 mm/min	121	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	1.3	%	ISO 527
Tensile Strain, break, 5 mm/min	1.3	%	ISO 527
Tensile Modulus, 1 mm/min	11990	MPa	ISO 527
Flexural Stress	180	MPa	ISO 178
Flexural Modulus, 2 mm/min	11050	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	42	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	6	cm-kgf/cm	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	30	cm-kgf	ASTM D 3763
Multiaxial Impact	20	cm-kgf	ISO 6603
Instrumented Impact Total Energy, 23°C	112	cm-kgf	ASTM D 3763
Izod Impact, unnotched 80°10*4 +23°C	24	kJ/m ²	ISO 180/1U

(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±176;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.

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
IMPACT			
Izod Impact, notched 80*10*4 +23°C	5	kJ/m ²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	278	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	264	°C	ASTM D 648
CTE, -40°C to 40°C, flow	2.3E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.8E-05	1/°C	ASTM E 831
CTE, -30°C to 30°C, flow	2.5E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	3.4E-05	1/°C	ASTM D 696
CTE, -40°C to 40°C, flow	2.4E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	5.E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	278	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	257	°C	ISO 75/Af
PHYSICAL			
Density	1.69	g/cm ³	ASTM D 792
Mold Shrinkage, flow, 24 hrs (5)	0.1 - 0.2	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs (5)	0.6 - 0.8	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs (5)	0.13 - 0.18	%	ISO 294
Mold Shrinkage, xflow, 24 hrs (5)	0.3 - 0.48	%	ISO 294
Wear Factor Washer	52	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Wear Factor Ring	7 - 8	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D 3702 Modified
Dynamic COF	0.44	-	ASTM D 3702 Modified
Static COF	0.35	-	ASTM D 3702 Modified
Density	1.7	g/cm ³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.01	%	ISO 62

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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

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