

LNP* Lubriloy* Compound Lexan_WR6300

Americas: COMMERCIAL

LNP* Lubriloy* Lexan_WR6300 compound is a wear resistant PC+SAN, with proprietary lubricant, for business equipment applications.

TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
MECHANICAL			
Tensile Stress, yld, Type I, 50 mm/min	610	kgf/cm ²	ASTM D 638
Tensile Stress, brk, Type I, 50 mm/min	620	kgf/cm ²	ASTM D 638
Tensile Strain, brk, Type I, 50 mm/min	164	%	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	980	kgf/cm ²	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	25300	kgf/cm ²	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	258	cm-kgf/cm	ASTM D 4812
Izod Impact, notched, 23°C	69	cm-kgf/cm	ASTM D 256
Izod Impact, notched, -30°C	16	cm-kgf/cm	ASTM D 256
Instrumented Impact Total Energy, 23°C	614	cm-kgf	ASTM D 3763
THERMAL			
Vicat Softening Temp, Rate B/50	136	°C	ASTM D 1525
HDT, 1.82 MPa, 3.2mm, unannealed	117	°C	ASTM D 648
HDT, 0.45 MPa, 6.4 mm, unannealed	133	°C	ASTM D 648
HDT, 1.82 MPa, 6.4 mm, unannealed	121	°C	ASTM D 648
CTE, -40°C to 40°C, flow	1.06E-04	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	1.19E-04	1/°C	ASTM E 831
Relative Temp Index, Elec	80	°C	UL 746B
Relative Temp Index, Mech w/impact	80	°C	UL 746B
Relative Temp Index, Mech w/o impact	80	°C	UL 746B
PHYSICAL			
Specific Gravity	1.17	-	ASTM D 792
Mold Shrinkage, flow, 3.2 mm (5)	0.5 - 0.7	%	SABIC Method
Melt Volume Rate, MVR at 300°C/2.16 kg	38	cm ³ /10 min	ISO 1133

(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.

Source GMD, last updated:

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TYPICAL PROPERTIES ¹	TYPICAL VALUE	Unit	Standard
FLAME CHARACTERISTICS			
UL Recognized, 94HB Flame Class Rating (3)	1.49	mm	UL 94

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PROCESSING PARAMETERS	TYPICAL VALUE	Unit
Injection Molding		
Drying Temperature	105	°C
Drying Time	3 - 4	hrs
Drying Time (Cumulative)	24	hrs
Maximum Moisture Content	0.02	%
Melt Temperature	250 - 270	°C
Nozzle Temperature	245 - 265	°C
Front - Zone 3 Temperature	250 - 270	°C
Middle - Zone 2 Temperature	240 - 260	°C
Rear - Zone 1 Temperature	225 - 250	°C
Mold Temperature	50 - 80	°C
Back Pressure	0.3 - 0.7	MPa
Screw Speed	40 - 70	rpm
Shot to Cylinder Size	40 - 60	%
Vent Depth	0.025 - 0.076	mm

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