LNP™ LUBRICOMP™ COMPOUND DBL32

DBL-4032
REGION ASIA

DESCRIPTION

LNP* LUBRICOMP* DBL32 is a compound based on Polycarbonate resin containing 10% Glass Beads and 15% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20190204

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	42	MPa	ASTM D 638
Tensile Stress, break	38	MPa	ASTM D 638
Tensile Strain, yield	5.4	%	ASTM D 638
Tensile Strain, break	22.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	2060	MPa	ASTM D 638
Flexural Modulus	2750	MPa	ASTM D 790
Tensile Stress, yield	43	MPa	ISO 527
Tensile Stress, break	38	MPa	ISO 527
Tensile Strain, yield	5.1	%	ISO 527
Tensile Strain, break	18.2	%	ISO 527
Tensile Modulus, 1 mm/min	2580	MPa	ISO 527
Flexural Stress	69	MPa	ISO 178
Flexural Modulus	2400	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1500	J/m	ASTM D 4812
Izod Impact, notched, 23°C	192	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	31	J	ASTM D 3763
Multiaxial Impact	25	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	105	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	14	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	142	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	135	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.4E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	5.94E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	5.3E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	6.E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	139	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	135	°C	ISO 75/Af
PHYSICAL			
Density	1.37	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.9 – 1.1	%	ASTM D 955

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Mold Shrinkage, flow, 24 hrs	0.8	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.96	%	ISO 294
Wear Factor Washer	139	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.41	-	ASTM D 3702 Modified: Manual
Static COF	0.48	-	ASTM D 3702 Modified: Manual
Density	1.37	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	305 – 325	°C	
Front - Zone 3 Temperature	320 – 330	°C	
Middle - Zone 2 Temperature	310 – 320	°C	
Rear - Zone 1 Temperature	295 – 305	°C	
Mold Temperature	80 – 110	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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