LNP™ LUBRICOMP™ COMPOUND DBL34

DBL4034

DESCRIPTION

LNP* Lubricomp* DBL34 is a compound based on Polycarbonate resin containing Glass Bead, PTFE. Added features of this material include: Internally Lubricated.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield, 5 mm/min	42	MPa	ISO 527
Tensile Stress, break, 5 mm/min	40	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	3.1	%	ISO 527
Tensile Strain, break, 5 mm/min	4.6	%	ISO 527
Tensile Modulus, 1 mm/min	2800	MPa	ISO 527
Flexural Stress, break, 2 mm/min	76	MPa	ISO 178
Flexural Strain, break, 2 mm/min	5.3	%	ISO 178
Flexural Modulus, 2 mm/min	2900	MPa	ISO 178
IMPACT			
Izod Impact, unnotched 80*10*4 +23°C	25	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	6	kJ/m²	ISO 180/1A
THERMAL			
CTE, 23°C to 60°C, flow	6.E-05	1/°C	ISO 11359-2
CTE, 23°C to 60°C, xflow	6.9E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	130	°C	ISO 75/Af
PHYSICAL			
Mold Shrinkage, flow	0.5 – 0.7	%	SABIC method
Wear Factor Washer	94	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Instr.
Dynamic COF	0.5	-	ASTM D 3702 Modified: Instr.
Static COF	0.7	-	ASTM D 3702 Modified: Instr.
Density	1.45	g/cm³	ISO 1183
Water Absorption, 23°C/24hrs	0.13	%	ISO 62-1
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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