LNP™ LUBRICOMP™ COMPOUND DCL33E

DCL4033

DESCRIPTION

LNP LUBRICOMP DCL33E is a compound based on Polycarbonate resin containing Carbon Fiber, PTFE. Added features include; Internally Lubricated, Electrically Conductive, Easy Molding.

TYPICAL PROPERTY VALUES

Revision 20191216

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break, 5 mm/min	121	MPa	ISO 527
Tensile Strain, break, 5 mm/min	1.8	%	ISO 527
Flexural Stress, break, 2 mm/min	177	MPa	ISO 178
Flexural Modulus, 2 mm/min	11900	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			
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	139	°C	ISO 75/Af
Relative Temp Index, Elec [1]	80	°C	UL 746B
Relative Temp Index, Mech w/impact [1]	80	°C	UL 746B
Relative Temp Index, Mech w/o impact [1]	80	°C	UL 746B
PHYSICAL			
Mold Shrinkage, flow	0.15 – 0.3	%	SABIC method
Density	1.35	g/cm³	ISO 1183
ELECTRICAL			
Surface Resistivity	1.E+02 – 1.E+04	Ohm	ASTM D 257
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E45329-101343782	-	-
UL Recognized, 94V-0 Flame Class Rating	≥4.5	mm	UL 94
UL Recognized, 94HB Flame Class Rating	≥0.8	mm	UL 94
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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(1) UL Ratings shown on the technical datasheet might not cover the full range of thicknesses and colors. For details, please see the UL Yellow Card.

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