LNP™ LUBRILOY™ COMPOUND DF204

DF-20

DESCRIPTION

LNP LUBRILOY DF204 is a compound based on Polycarbonate resin containing 20% Glass Fiber, Proprietary Lubricant. Added feature of th is grade is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	105	MPa	ASTM D 638
Tensile Strain, break	2.8	%	ASTM D 638
Tensile Modulus, 50 mm/min	6750	MPa	ASTM D 638
Flexural Stress	158	MPa	ASTM D 790
Flexural Modulus	5990	MPa	ASTM D 790
IMPACT			
Izod Impact, unnotched, 23°C	758	J/m	ASTM D 4812
Izod Impact, notched, 23°C	181	J/m	ASTM D 256
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	142	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	137	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.38E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	6.84E-05	1/°C	ASTM E 831
Thermal Conductivity	0.25	W/m-°C	ASTM E 1530
PHYSICAL			
Density	1.32	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.2 – 0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.2 – 0.3	%	ASTM D 955
Wear Factor Washer	179	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.41	-	ASTM D 3702 Modified: Manual
Static COF	0.39	-	ASTM D 3702 Modified: Manual
INJECTION MOLDING			
Drying Temperature	100	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	305 – 315	°C	
Front - Zone 3 Temperature	305 – 315	°C	
Middle - Zone 2 Temperature	300 – 310	°C	
Rear - Zone 1 Temperature	295 – 305	°C	
Mold Temperature	65 – 95	°C	
Back Pressure	0.2 – 0.3	MPa	
Screw Speed	30 – 60	rpm	

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