LNP™ LUBRILOY™ COMPOUND DF206XXH

DF-30 HC

DESCRIPTION

LNP LUBRILOY DF206XXH is a compound based on Polycarbonate containing 30% Glass Fiber, Proprietary Lubricant. Added features of this grade include: Wear Resistant, Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, brk, Type I, 5 mm/min	112	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.6	%	ASTM D 638
Tensile Modulus, 5 mm/min	8720	MPa	ASTM D 638
Flexural Stress, yld, 1.3 mm/min, 50 mm span	174	MPa	ASTM D 790
Flexural Stress, brk, 1.3 mm/min, 50 mm span	169	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	7830	MPa	ASTM D 790
Tensile Stress, break, 5 mm/min	112	MPa	ISO 527
Tensile Strain, break, 5 mm/min	2.6	%	ISO 527
Tensile Modulus, 1 mm/min	8240	MPa	ISO 527
Flexural Stress	166	MPa	ISO 178
Flexural Modulus, 2 mm/min	7580	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	775	J/m	ASTM D 4812
Izod Impact, notched, 23°C	178	J/m	ASTM D 256
Multiaxial Impact	6	J	ISO 6603
Instrumented Impact Total Energy, 23°C	26	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	49	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	17	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	146	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	142	°C	ASTM D 648
CTE, -30°C to 30°C, flow	5.6E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	5.1E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	145	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.4	-	ASTM D 792
Density	1.39	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.11	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.4 – 0.6	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5 – 0.7	%	ASTM D 955
Wear Factor Washer	245	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Wear Factor Ring	27	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.49	-	ASTM D 3702 Modified: Manual

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Static COF	0.64	-	ASTM D 3702 Modified: Manual
Moisture Absorption (23°C / 50% RH)	0.16	%	ISO 62
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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