LNP™ LUBRICOMP™ COMPOUND DFI14

DFL-4414

DESCRIPTION

LNP LUBRICOMP DFI14 is a compound based on Polycarbonate resin containing 20% Glass Fiber and 2% Silicone. Added features include: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	104	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	103	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	3.3	%	ASTM D 638
Tensile Modulus, 5 mm/min	6270	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	171	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	6080	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	103	MPa	ISO 527
Tensile Stress, break, 5 mm/min	102	MPa	ISO 527
Tensile Strain, break, 5 mm/min	3.1	%	ISO 527
Tensile Modulus, 1 mm/min	6210	MPa	ISO 527
Flexural Stress	164	MPa	ISO 178
Flexural Modulus, 2 mm/min	5890	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	752	J/m	ASTM D 4812
Izod Impact, notched, 23°C	171	J/m	ASTM D 256
Multiaxial Impact	7	J	ISO 6603
Instrumented Impact Total Energy, 23°C	24	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	52	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	145	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	141	°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	6.9E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	144	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	140	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.33	-	ASTM D 792
Density	1.33	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.3 – 0.5	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.6 – 0.8	%	ASTM D 955
Wear Factor Washer	276	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Wear Factor Ring	4	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.43	-	ASTM D 3702 Modified: Manual
Static COF	0.53	-	ASTM D 3702 Modified: Manual
Moisture Absorption (23°C / 50% RH)	0.18	%	ISO 62
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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