LNP™ LUBRICOMP™ COMPOUND DFL329

DFL-4032 FR

DESCRIPTION

LNP LUBRICOMP* DFL329 is a compound based on Polycarbonate resin containing 10% Glass Fiber, 15% PTFE. Added features of this material include: Flame Retardant, Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20200110

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, break	75	MPa	ASTM D 638
Tensile Strain, break	3	%	ASTM D 638
Tensile Modulus, 50 mm/min	4340	MPa	ASTM D 638
Flexural Stress	129	MPa	ASTM D 790
Flexural Modulus	4270	MPa	ASTM D 790
Tensile Stress, break	74	MPa	ISO 527
Tensile Strain, break	3	%	ISO 527
Tensile Modulus, 1 mm/min	4500	MPa	ISO 527
Flexural Stress	127	MPa	ISO 178
Flexural Modulus	4600	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	550	J/m	ASTM D 4812
Izod Impact, notched, 23°C	181	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	18	J	ASTM D 3763
Multiaxial Impact	3	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	38	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	9	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	141	°C	ASTM D 648
CTE, -40°C to 40°C, flow	4.48E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	4.98E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	4.48E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	4.99E-05	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Af
PHYSICAL			
Density	1.4	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.12	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.3	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.33	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.49	%	ISO 294
Density	1.4	g/cm³	ISO 1183
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
FLAME CHARACTERISTICS [1]			
UL Yellow Card Link	E121562-101284270	-	-
UL Yellow Card Link 2	E207780-101284354	-	-
UL Recognized, 94V-0 Flame Class Rating	1.7	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	

(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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