LNP™ LUBRICOMP™ COMPOUND DFL36G

DFL-4036 MG
REGION ASIA

DESCRIPTION

LNP* LUBRICOMP* DFL36G is a compound based on Polycarbonate resin containing 30% Mixed Glass, 15% PTFE. Added feature of this material is: Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20181205

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	91	MPa	ASTM D 638
Tensile Stress, break	86	MPa	ASTM D 638
Tensile Strain, yield	2.3	%	ASTM D 638
Tensile Strain, break	2.4	%	ASTM D 638
Tensile Modulus, 50 mm/min	7580	MPa	ASTM D 638
Flexural Stress	137	MPa	ASTM D 790
Flexural Modulus	6890	MPa	ASTM D 790
Tensile Stress, yield	90	MPa	ISO 527
Tensile Stress, break	90	MPa	ISO 527
Tensile Strain, yield	2.3	%	ISO 527
Tensile Strain, break	2.3	%	ISO 527
Tensile Modulus, 1 mm/min	7280	MPa	ISO 527
Flexural Stress	3	MPa	ISO 178
Flexural Modulus	7000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	133	J/m	ASTM D 4812
Izod Impact, notched, 23°C	566	J/m	ASTM D 256
Instrumented Impact Energy @ peak, 23°C	18	J	ASTM D 3763
Multiaxial Impact	5	J	ISO 6603
Izod Impact, unnotched 80*10*4 +23°C	37	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	12	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	143	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	138	°C	ASTM D 648
CTE, -40°C to 40°C, flow	5.76E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, xflow	2.88E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	5.8E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	2.8E-05	1/°C	ISO 11359-2
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			
Density	1.55	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.1 – 0.3	%	ASTM D 955

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Mold Shrinkage, xflow, 24 hrs	0.3 – 0.5	%	ASTM D 955
Mold Shrinkage, flow, 24 hrs	0.24	%	ISO 294
Mold Shrinkage, xflow, 24 hrs	0.43	%	ISO 294
Wear Factor Washer	41	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.49	-	ASTM D 3702 Modified: Manual
Static COF	0.41	-	ASTM D 3702 Modified: Manual
Density	1.54	g/cm³	ISO 1183
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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