LNP™ LUBRICOMP™ COMPOUND DL003EU

DL-4030 EM UV

DESCRIPTION

LNP LUBRICOMP* DL003EU is a compound based on Polycarbonate resin containing 15% PTFE. Added features of this material include: Easy Molding, UV Stabilized, Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191218

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yield	45	MPa	ASTM D 638
Tensile Stress, break	50	MPa	ASTM D 638
Tensile Strain, yield	5.6	%	ASTM D 638
Tensile Strain, break	25.5	%	ASTM D 638
Tensile Modulus, 50 mm/min	2180	MPa	ASTM D 638
Flexural Stress	82	MPa	ASTM D 790
Flexural Modulus	2300	MPa	ASTM D 790
Tensile Stress, yield	54	MPa	ISO 527
Tensile Stress, break	50	MPa	ISO 527
Tensile Strain, yield	5.5	%	ISO 527
Tensile Strain, break	9.6	%	ISO 527
Tensile Modulus, 1 mm/min	2200	MPa	ISO 527
Flexural Stress	84	MPa	ISO 178
Flexural Modulus	2300	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	2136	J/m	ASTM D 4812
Izod Impact, notched, 23°C	143	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	100	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	16	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	116	°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	7.55E-05	1/°C	ASTM E 831
CTE, -40°C to 40°C, flow	7.4E-05	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.5E-05	1/°C	ISO 11359-2
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	138	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	128	°C	ISO 75/Af
PHYSICAL			
Density	1.28	g/cm³	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.8 – 0.9	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.8 – 0.9	%	ASTM D 955
Wear Factor Washer	60	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.18	-	ASTM D 3702 Modified: Manual
Static COF	0.07	-	ASTM D 3702 Modified: Manual

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Density	1.29	g/cm³	ISO 1183
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	300 – 315	°C	
Front - Zone 3 Temperature	310 – 320	°C	
Middle - Zone 2 Temperature	305 – 315	°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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