LNP™ LUBRICOMP™ COMPOUND DL003EXJ

DL-4030 EM LE HC

DESCRIPTION

LNP* LUBRICOMP* DL003EXJ is a compound based on Polycarbonate containing 15% PTFE. Characteristics of this grade are Easy Molding, Low Extractable, Wear Resistant, Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191219

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	46	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	38	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	5.6	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	17.3	%	ASTM D 638
Tensile Modulus, 50 mm/min	2090	MPa	ASTM D 638
Flexural Modulus, 1.3 mm/min, 50 mm span	2190	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	45	MPa	ISO 527
Tensile Stress, break, 5 mm/min	34	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5.4	%	ISO 527
Tensile Strain, break, 5 mm/min	21.8	%	ISO 527
Tensile Modulus, 1 mm/min	1980	MPa	ISO 527
Flexural Stress	67	MPa	ISO 178
Flexural Modulus, 2 mm/min	2000	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	1780	J/m	ASTM D 4812
Izod Impact, notched, 23°C	176	J/m	ASTM D 256
Multiaxial Impact	28	J	ISO 6603
Instrumented Impact Total Energy, 23°C	33	J	ASTM D 3763
Izod Impact, unnotched 80*10*4 +23°C	110	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	141	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	130	°C	ASTM D 648
CTE, -30°C to 30°C, flow	7.7E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	7.7E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	141	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	124	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.29	-	ASTM D 792
Density	1.29	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.1	%	ASTM D 570
Mold Shrinkage, flow, 24 hrs	0.6 – 0.8	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.7 – 0.9	%	ASTM D 955
Wear Factor Washer	15	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	0	10^-10 in^5-min/ft-lb-hr	ASTM D 3702 Modified: Manual
Dynamic COF	0.38	-	ASTM D 3702 Modified: Manual
Static COF	0.23	-	ASTM D 3702 Modified: Manual
Moisture Absorption (23°C / 50% RH)	0.15	%	ISO 62
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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