LNP™ LUBRICOMP™ COMPOUND DX07404H

DX07404H

DESCRIPTION

LNP LUBRICOMP DX07404H is a compound based on Polycarbonate containing Proprietary Fillers. Added features of this grade are: Healthcare, Wear Resistant.

TYPICAL PROPERTY VALUES

Revision 20191210

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	60	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	50	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	5	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	54	%	ASTM D 638
Tensile Modulus, 5 mm/min	2490	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	89	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2380	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	59	MPa	ISO 527
Tensile Stress, break, 5 mm/min	49	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	5	%	ISO 527
Tensile Strain, break, 5 mm/min	58	%	ISO 527
Tensile Modulus, 1 mm/min	2270	MPa	ISO 527
Flexural Stress, break, 2 mm/min	81	MPa	ISO 178
Flexural Modulus, 2 mm/min	2380	MPa	ISO 178
IMPACT			
Izod Impact, notched, 23°C	133	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	179	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m²	ISO 180/1A
THERMAL			
HDT, 0.45 MPa, 3.2 mm, unannealed	135	°C	ASTM D 648
HDT, 1.82 MPa, 3.2mm, unannealed	124	°C	ASTM D 648
CTE, -30°C to 30°C, flow	6.4E-05	1/°C	ASTM D 696
CTE, -30°C to 30°C, xflow	6.5E-05	1/°C	ASTM D 696
HDT/Bf, 0.45 MPa Flatw 80*10*4 sp=64mm	135	°C	ISO 75/Bf
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	125	°C	ISO 75/Af
PHYSICAL			
Density	1.25	g/cm³	ASTM D 792
Moisture Absorption, 50% RH, 24 hrs	0.14	%	ASTM D 570
Mold Shrinkage, flow	0.4 – 0.6	%	SABIC method
Mold Shrinkage, xflow	0.5 – 0.7	%	SABIC method
Mold Shrinkage, flow, 24 hrs	0.5 – 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.5 – 0.7	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.18	%	ISO 62
INJECTION MOLDING			

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Drying Temperature	120	°C	
Drying Time	2 – 4	hrs	
Maximum Moisture Content	0.02	%	
Melt Temperature	280 – 300	°C	
Front - Zone 3 Temperature	280 – 300	°C	
Middle - Zone 2 Temperature	270 – 290	°C	
Rear - Zone 1 Temperature	260 – 280	°C	
Mold Temperature	80 – 110	°C	

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