LNP™ LUBRICOMP™ COMPOUND DX09407H

DX09407H

DESCRIPTION

LNP LUBRICOMP DX09407H is a compound based on High Heat Polycarbonate containing proprietary fillers. Added features of this grade are: Wear Resistant, Healthcare.

TYPICAL PROPERTY VALUES

Revision 20191211

PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
MECHANICAL			
Tensile Stress, yld, Type I, 5 mm/min	64	MPa	ASTM D 638
Tensile Stress, brk, Type I, 5 mm/min	53	MPa	ASTM D 638
Tensile Strain, yld, Type I, 5 mm/min	6.8	%	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	68	%	ASTM D 638
Tensile Modulus, 5 mm/min	2230	MPa	ASTM D 638
Flexural Stress, brk, 1.3 mm/min, 50 mm span	90	MPa	ASTM D 790
Flexural Modulus, 1.3 mm/min, 50 mm span	2300	MPa	ASTM D 790
Tensile Stress, yield, 5 mm/min	64	MPa	ISO 527
Tensile Stress, break, 5 mm/min	56	MPa	ISO 527
Tensile Strain, yield, 5 mm/min	6.9	%	ISO 527
Tensile Strain, break, 5 mm/min	111	%	ISO 527
Tensile Modulus, 1 mm/min	2130	MPa	ISO 527
Flexural Strain, break, 2 mm/min	76.8	%	ISO 178
Flexural Modulus, 2 mm/min	2080	MPa	ISO 178
IMPACT			
Izod Impact, unnotched, 23°C	2214	J/m	ASTM D 4812
Izod Impact, notched, 23°C	139	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	191	kJ/m²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	11	kJ/m²	ISO 180/1A
THERMAL			
HDT, 1.82 MPa, 3.2mm, unannealed	139	°C	ASTM D 648
CTE, -40°C to 40°C, flow	7.43E+01	1/°C	ISO 11359-2
CTE, -40°C to 40°C, xflow	7.67E+01	1/°C	ISO 11359-2
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	137	°C	ISO 75/Af
PHYSICAL			
Specific Gravity	1.21	-	ASTM D 792
Mold Shrinkage, flow, 24 hrs	0.5 – 0.7	%	ASTM D 955
Mold Shrinkage, xflow, 24 hrs	0.6 – 0.8	%	ASTM D 955
Moisture Absorption (23°C / 50% RH)	0.21	%	ISO 62
INJECTION MOLDING			
Drying Temperature	120	°C	
Drying Time	3 – 4	hrs	
Drying Time (Cumulative)	48	hrs	
Maximum Moisture Content	0.02	%	

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PROPERTIES	TYPICAL VALUES	UNITS	TEST METHODS
Melt Temperature	295 – 315	°C	
Nozzle Temperature	290 – 310	°C	
Front - Zone 3 Temperature	295 – 315	°C	
Middle - Zone 2 Temperature	280 – 305	°C	
Rear - Zone 1 Temperature	270 – 295	°C	
Mold Temperature	70 – 95	°C	
Back Pressure	0.3 – 0.7	MPa	
Screw Speed	40 – 70	rpm	
Shot to Cylinder Size	40 – 60	%	
Vent Depth	0.025 – 0.076	mm	

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