

LNP™ LUBRICOMP™ DL003E compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP LUBRICOMP* DL003E is a compound based on Polycarbonate resin containing PTFE. Added features of this material include: Easy Molding.
Also known as: LNP* LUBRICOMP* Compound DL-4030 EM
Product reorder name: DL003E

General Information			
Additive	PTFE lubricant		
Features	Good formability		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.28	g/cm ³	ASTM D792
--	1.29	g/cm ³	ISO 1183
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.80 - 0.90	%	ASTM D955
Transverse flow: 24 hours	0.80 - 0.90	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2190	MPa	ASTM D638
--	2200	MPa	ISO 527-2/1
Tensile Strength			
Yield	45.1	MPa	ASTM D638
Yield	54.0	MPa	ISO 527-2
Fracture	50.3	MPa	ASTM D638
Fracture	50.0	MPa	ISO 527-2
Tensile Elongation			
Yield	5.6	%	ASTM D638
Yield	5.5	%	ISO 527-2
Fracture	26	%	ASTM D638
Fracture	9.6	%	ISO 527-2
Flexural Modulus			
--	2310	MPa	ASTM D790
--	2300	MPa	ISO 178
Flexural Strength			
--	82.5	MPa	ASTM D790
--	84.0	MPa	ISO 178

Coefficient of Friction		ASTM D3702 Modified	
With self-dynamics	0.18	ASTM D3702 Modified	
With Self-Static	0.070	ASTM D3702 Modified	
Wear Factor - Washer	60.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	140	J/m	ASTM D256
23°C ²	16	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	2100	J/m	ASTM D4812
23°C ³	100	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, unannealed, 64.0mm span ⁴	138	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	117	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	128	°C	ISO 75-2/Af
Linear thermal expansion coefficient			
Flow: -40 to 40°C	7.4E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	7.6E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	7.5E-5	cm/cm/°C	ISO 11359-2
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 - 304	°C	
Middle Temperature	304 - 316	°C	
Front Temperature	310 - 321	°C	
Processing (Melt) Temp	299 - 316	°C	
Mold Temperature	82.2 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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