

LNP™ LUBRICOMP™ DFL23 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DFL23 is a compound based on Polycarbonate resin containing 15% Glass Fiber and 10% PTFE. Added feature of this material is: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound DFL-4023

Product reorder name: DFL23

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Additive	PTFE Lubricant (10%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.38	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.30 to 0.50	%	ASTM D955
Across Flow : 24 hr	0.50 to 0.70	%	ASTM D955
Across Flow : 24 hr	0.60	%	ISO 294-4
Flow : 24 hr	0.38	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5520	MPa	ASTM D638
--	5330	MPa	ISO 527-2/1
Tensile Strength			
Yield	88.9	MPa	ASTM D638
Yield	88.0	MPa	ISO 527-2
Break	67.6	MPa	ASTM D638
Break	88.0	MPa	ISO 527-2
Tensile Elongation			
Yield	3.1	%	ASTM D638
Yield	3.0	%	ISO 527-2
Break	3.5	%	ASTM D638
Break	3.1	%	ISO 527-2
Flexural Modulus			
--	4830	MPa	ASTM D790
--	5100	MPa	ISO 178

Flexural Strength			
--	138	MPa	ASTM D790
--	142	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.50		
vs. Itself - Static	0.55		
Wear Factor - Washer	163	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	150	J/m	ASTM D256
23°C ²	13	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	760	J/m	ASTM D4812
23°C ³	44	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	23.3	J	ASTM D3763
--	7.60	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	145	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	145	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	140	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	141	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	4.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	4.3E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 to 304	°C	
Middle Temperature	310 to 321	°C	
Front Temperature	321 to 332	°C	
Processing (Melt) Temp	304 to 327	°C	
Mold Temperature	82.2 to 110	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

