

LNP™ LUBRICOMP™ DP001E compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DP001E is a Polycarbonate base resin containing 5% PTFE/Silicone. Added features of this material include: Easy Molding, Wear Resistant.
Also known as: LNP* LUBRICOMP* Compound DL-4510 EM
Product reorder name: DP001E

General Information			
Additive	PTFE + Silicone Lubricant (5%)		
Features	Good Moldability		
	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.20	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.50	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Water Absorption			
24 hr, 50% RH	0.12	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.17	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2240	MPa	ASTM D638
--	2130	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	54.0	MPa	ASTM D638
Yield	54.0	MPa	ISO 527-2/5
Break ³	45.0	MPa	ASTM D638
Break	41.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	6.0	%	ASTM D638
Yield	6.0	%	ISO 527-2/5
Break ⁵	38	%	ASTM D638
Break	48	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	2230	MPa	ASTM D790
-- ⁷	2030	MPa	ISO 178

Flexural Stress	72.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.21		
vs. Itself - Static	0.11		
Wear Factor			ASTM D3702 Modified
Ring	0.100 to 0.200	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	154	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	600	J/m	ASTM D256
23°C ⁸	36	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1500	J/m	ASTM D4812
23°C ⁹	180	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	35.2	J	ASTM D3763
--	44.7	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	141	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	140	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	127	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	126	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	6.9E-5	cm/cm/°C	
Transverse : -30 to 30°C	7.1E-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	304 to 316	°C	
Front Temperature	310 to 321	°C	
Processing (Melt) Temp	299 to 316	°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.	Type I, 5.0 mm/min		
3.	Type I, 5.0 mm/min		
4.	Type I, 5.0 mm/min		

5.	Type I, 5.0 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	80*10*4
9.	80*10*4
10.	80*10*4 mm
11.	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

