LNP™ LUBRICOMP™ DFL28EG compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DFL28EG is a compound based on Polycarbonate resin containing 40% Glass Fiber/Milled Glass and 10% PTFE. Added features of this material are: Wear Resistant, Easy Molding.
Also known as: LNP* LUBRICOMP* Compound DFL-4028 EM MG
Product reorder name: DFL28EG

General Information			
Filler / Reinforcement	Glass Milled\Glass Fiber,40% Filler by Weight		
Additive	PTFE Lubricant (10%)		
Features	Good Moldability Good Wear Resistance Lubricated		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity			ASTM D792
--	1.62	g/cm³	
--	1.61	g/cm³	
Molding Shrinkage - Across Flow (24 hr)	0.30 to 0.60	%	ASTM D955
Water Absorption			
24 hr, 50% RH	0.080	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.12	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	11000	MPa	ASTM D638
--	10200	MPa	ISO 527-2/1
Tensile Strength			
Yield [2]	115	MPa	ASTM D638
Yield	116	MPa	ISO 527-2/5
Break [3]	115	MPa	ASTM D638
Break	116	MPa	ISO 527-2/5
Tensile Elongation			
Yield [4]	1.9	%	ASTM D638
Yield	1.9	%	ISO 527-2/5
Break	0.0	%	ASTM D638
Break [5]	1.9	%	ASTM D638
Break	2.0	%	ISO 527-2/5
Flexural Modulus			

50.0 mm Span [6]	9860	MPa	ASTM D790
-- [7]	9780	MPa	ISO 178
Flexural Stress			
--	174	MPa	ISO 178
Yield, 50.0 mm Span [8]	176	MPa	ASTM D790
Break, 50.0 mm Span [9]	176	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.61		
vs. Itself - Static	0.58		
Wear Factor			ASTM D3702 Modified
Ring	2.60	10^-10 in^5-min/ft-lb-hr	
Washer	45.0	10^-10 in^5-min/ft-lb-hr	
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C [10]	12	kJ/m²	ISO 180/1A
Unnotched Izod Impact			
23°C	650	J/m	ASTM D4812
23°C [11]	41	kJ/m²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	19.9	J	ASTM D3763
--	4.80	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 [12]	141	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	140	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span [13]	139	°C	ISO 75-2/Af
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.	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.	1.3 mm/min
9.	1.3 mm/min
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	80*10*4 mm

Recommended distributors for this material

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