

LNP™ LUBRICOMP™ DBL349E compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DBL349E is a compound based on Polycarbonate resin containing 20% Glass Bead, 15% PTFE. Added features of this material include: Wear Resistant, Flame Retardant.

Also known as: LNP* LUBRICOMP* Compound DBL-4034 EM FR

Product reorder name: DBL349E

General Information			
UL YellowCard	E121562-101284257		
Filler / Reinforcement	Glass Bead,20% Filler by Weight		
Additive	PTFE Lubricant (15%)		
Features	Flame Retardant		
	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.48	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.40 to 0.60	%	ASTM D955
Across Flow : 24 hr	0.60 to 0.80	%	ASTM D955
Across Flow : 24 hr	0.69	%	ISO 294-4
Flow : 24 hr	0.54	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	3450	MPa	ASTM D638
--	2970	MPa	ISO 527-2/1
Tensile Strength			
Yield	41.4	MPa	ASTM D638
Yield	41.0	MPa	ISO 527-2
Break	37.9	MPa	ASTM D638
Break	38.0	MPa	ISO 527-2
Tensile Elongation			
Yield	2.9	%	ASTM D638, ISO 527-2
Break	9.0	%	ASTM D638
Break	7.6	%	ISO 527-2
Flexural Modulus			
--	2760	MPa	ASTM D790
--	2900	MPa	ISO 178

Flexural Stress	78.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.52		
vs. Itself - Static	0.70		
Wear Factor - Washer	90.5	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	59	J/m	ASTM D256
23°C ²	5.6	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	460	J/m	ASTM D4812
23°C ³	31	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	15.7	J	ASTM D3763
--	4.50	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 ⁴	140	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	129	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	129	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	6.5E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Transverse : -40 to 40°C	6.5E-5	cm/cm/°C	ASTM E831
Transverse : -40 to 40°C	6.4E-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 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		
5.	80*10*4 mm		

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