

LNP™ LUBRICOMP™ DFP34 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DFP34 is a compound based on Polycarbonate resin containing Glass Fiber, PTFE, Silicone. Added features of this material include: Internally Lubricated.

Also known as: LNP* LUBRICOMP* Compound DFL-4534

Product reorder name: DFP34

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	PTFE silicone lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.30 - 0.50	%	ASTM D955
Transverse flow: 24 hours	0.30 - 0.50	%	ASTM D955
Vertical flow direction: 24 hours	0.44	%	ISO 294-4
Flow direction: 24 hours	0.36	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6890	MPa	ASTM D638
--	6740	MPa	ISO 527-2/1
Tensile Strength			
Yield	103	MPa	ASTM D638, ISO 527-2
Fracture	103	MPa	ASTM D638
Fracture	104	MPa	ISO 527-2
Tensile Elongation			
Yield	2.8	%	ASTM D638
Yield	2.5	%	ISO 527-2
Fracture	2.8	%	ASTM D638
Fracture	2.5	%	ISO 527-2
Flexural Modulus			
--	6210	MPa	ASTM D790
--	6400	MPa	ISO 178
Flexural Strength			
--	159	MPa	ASTM D790
--	158	MPa	ISO 178

Coefficient of Friction		ASTM D3702 Modified	
With self-dynamics	0.51	ASTM D3702 Modified	
With Self-Static	0.53	ASTM D3702 Modified	
Wear Factor - Washer	108	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	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	720	J/m	ASTM D4812
23°C ³	44	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	24.9	J	ASTM D3763
--	6.30	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	144	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁴	145	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	141	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	141	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	4.7E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	3.6E-5	cm/cm/°C	ASTM E831, 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	310 - 321	°C	
Front Temperature	321 - 332	°C	
Processing (Melt) Temp	304 - 327	°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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