

LNP™ LUBRICOMP™ DL002ER compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DL002ER is a compound based on Polycarbonate resin containing 10% PTFE. Added features of this material include: Wear Resistant, Easy Molding, Mold Release.

Also known as: LNP* LUBRICOMP* Compound DL-4020 EM MR

Product reorder name: DL002ER

General Information			
Additive	Mold Release		
	PTFE Lubricant (10%)		
Features	Good Mold Release		
	Good Moldability		
	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.24	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.60 to 0.80	%	ASTM D955
Across Flow : 24 hr	0.70 to 0.90	%	ASTM D955
Across Flow : 24 hr	0.79	%	ISO 294-4
Flow : 24 hr	0.70	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2070	MPa	ASTM D638
--	2200	MPa	ISO 527-2/1
Tensile Strength			
Yield	55.8	MPa	ASTM D638
Yield	56.0	MPa	ISO 527-2
Break	49.0	MPa	ASTM D638
Break	46.0	MPa	ISO 527-2
Tensile Elongation			
Yield	5.9	%	ASTM D638
Yield	5.8	%	ISO 527-2
Break	66	%	ASTM D638
Break	71	%	ISO 527-2

Flexural Modulus			
--	2070	MPa	ASTM D790
--	2200	MPa	ISO 178
Flexural Stress	73.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.24		
vs. Itself - Static	0.075		
Wear Factor - Washer	34.5	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	130	J/m	ASTM D256
23°C ²	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	2500	J/m	ASTM D4812
23°C ³	170	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	40.2	J	ASTM D3763
--	44.3	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	135	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	135	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	124	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	125	°C	ISO 75-2/Af
CLTE			
Flow : -40 to 40°C	7.6E-5	cm/cm/°C	ASTM E831
Flow : -40 to 40°C	7.5E-5	cm/cm/°C	ISO 11359-2
Transverse : -40 to 40°C	7.2E-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 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.	80*10*4		

3.	80*10*4
4.	80*10*4 mm
5.	80*10*4 mm

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