

LNP™ LUBRICOMP™ DX07035 compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP DX07035 is a compound based on Polycarbonate resin containing Glass Fiber, PTFE, Flame Retardant. Added features include: Flame retardant, Easy Molding, Internally Lubricated, Mold Release.

General Information			
UL YellowCard	E45329-101283856		
Filler / Reinforcement	Glass Fiber		
Additive	Mold Release		
	PTFE Lubricant		
Features	Flame Retardant		
	Good Moldability		
	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.59	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.10 to 0.30	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9200	MPa	ISO 527-2/1
Tensile Stress (Yield)	109	MPa	ISO 527-2/5
Tensile Strain (Yield)	1.7	%	ISO 527-2/5
Flexural Modulus ¹	7400	MPa	ISO 178
Flexural Stress	150	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	40	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	143	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	138	°C	ISO 75-2/Af
Flammability	Nominal Value	Test Method	
Flame Rating (1.60 mm, Testing by SABIC)	V-0	UL 94	
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. | 2.0 mm/min |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 80*10*4 mm |

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