

LNP™ LUBRICOMP™ DBL34 compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP* Lubricomp* DBL34 is a compound based on Polycarbonate resin containing Glass Bead, PTFE. Added features of this material include: Internally Lubricated.

Also known as: LNP* LUBRICOMP* Compound DBL4034

Product reorder name: DBL34

General Information			
Filler / Reinforcement	Glass Bead		
Additive	PTFE Lubricant		
Features	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.45	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.50 to 0.70	%	Internal Method
Water Absorption (23°C, 24 hr)	0.13	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2/1
Tensile Stress			ISO 527-2/5
Yield	42.0	MPa	
Break	40.0	MPa	
Tensile Strain			ISO 527-2/5
Yield	3.1	%	
Break	4.6	%	
Flexural Modulus ¹	2900	MPa	ISO 178
Flexural Stress	76.0	MPa	ISO 178
Coefficient of Friction (vs. Itself - Dynamic)	0.50		ASTM D3702 Modified
Flexural Strain at Break ²	5.3	%	ISO 178
Wear Factor - Washer	94.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ³ (23°C)	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ⁴ (23°C)	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁵			
0.45 MPa, Unannealed, 64.0 mm Span	137	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	130	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	6.0E-5	cm/cm/°C	

Transverse : 23 to 60°C	6.9E-5	cm/cm/°C
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. | 2 mm/min |
| 3. | 80*10*4 |
| 4. | 80*10*4 |
| 5. | 80*10*4 mm |

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