

LNP™ LUBRICOMP™ DFL34EH compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DFL34EH is a compound based on Polycarbonate containing 20% Glass Fiber, 15% PTFE. Added features of this material include: Easy Molding, Healthcare, Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound DFL-4034 EM HC

Product reorder name: DFL34EH

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	PTFE Lubricant (15%)		
Features	Good Moldability		
	Good Wear Resistance		
	Lubricated		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.48	g/cm ³	
--	1.47	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.020 to 0.040	%	
Across Flow : 24 hr	0.20 to 0.40	%	
Water Absorption			
24 hr, 50% RH	0.090	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.13	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7190	MPa	ASTM D638
--	6650	MPa	ISO 527-2/1
Tensile Strength			
Break ²	95.0	MPa	ASTM D638
Break	93.0	MPa	ISO 527-2/5
Tensile Strain			
Yield	2.8	%	ISO 527-2/5
Break ³	2.7	%	ASTM D638
Break	3.1	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	6320	MPa	ASTM D790

-- ⁵	6200	MPa	ISO 178
Flexural Stress			
--	150	MPa	ISO 178
Break, 50.0 mm Span ⁶	145	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.46		
vs. Itself - Static	0.50		
Wear Factor			ASTM D3702 Modified
Ring	13.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	89.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	150	J/m	ASTM D256
23°C ⁷	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	740	J/m	ASTM D4812
23°C ⁸	49	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	19.6	J	ASTM D3763
--	6.60	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	146	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁹	146	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	142	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹⁰	141	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.7E-5	cm/cm/°C	
Transverse : -30 to 30°C	6.3E-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.	50 mm/min		

2.	Type I, 5.0 mm/min
3.	Type I, 5.0 mm/min
4.	1.3 mm/min
5.	2.0 mm/min
6.	1.3 mm/min
7.	80*10*4
8.	80*10*4
9.	80*10*4 mm
10.	80*10*4 mm

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