

LNP™ LUBRICOMP™ DL004 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DL004 is a compound based on Polycarbonate resin containing PTFE. Added features of this material include: Internally Lubricated.

Also known as: LNP* LUBRICOMP* Compound DL-4040

Product reorder name: DL004

General Information			
UL YellowCard	E207780-101343861		
Additive	PTFE lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.30	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.60	%	ASTM D955
Transverse flow: 24 hours	0.60	%	ASTM D955
Vertical flow direction: 24 hours	0.64	%	ISO 294-4
Flow direction: 24 hours	0.59	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.20	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2070	MPa	ASTM D638
--	2050	MPa	ISO 527-2/1
Tensile Strength			
Yield	42.7	MPa	ASTM D638
Yield	44.0	MPa	ISO 527-2
Fracture	38.6	MPa	ASTM D638
Fracture	39.0	MPa	ISO 527-2
Tensile Elongation			
Yield	6.1	%	ASTM D638
Yield	5.9	%	ISO 527-2
Fracture	29	%	ASTM D638, ISO 527-2
Flexural Modulus			
--	2070	MPa	ASTM D790
--	2000	MPa	ISO 178
Flexural Strength			
--	73.8	MPa	ASTM D790
--	63.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified

With self-dynamics	0.34		ASTM D3702 Modified
With Self-Static	0.19		ASTM D3702 Modified
Wear Factor - Washer	7.50	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	110	J/m	ASTM D256
23°C ²	12	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	1900	J/m	ASTM D4812
23°C ³	180	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	24.8	J	ASTM D3763
--	21.1	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	141	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ⁴	143	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	128	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	129	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	7.7E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	7.6E-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	304 - 316	°C	
Front Temperature	310 - 321	°C	
Processing (Melt) Temp	299 - 316	°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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