

LNP™ LUBRICOMP™ DFL36E compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP DFL36E is a compound based on Polycarbonate resin containing Glass Fiber, PTFE. Added features include; Internally Lubricated, Easy Molding.

Also known as: LNP* LUBRICOMP* Compound DFL-4036 EM

Product reorder name: DFL36E

General Information			
Filler / Reinforcement	Glass Fiber		
Additive	PTFE Lubricant		
Features	Good Moldability		
	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.55	g/cm³	ISO 1183
Molding Shrinkage - Flow	0.16	%	Internal Method
Water Absorption (23°C, 24 hr)	0.11	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	8400	MPa	ISO 527-2/1
Tensile Stress (Break)	118	MPa	ISO 527-2/5
Tensile Strain (Break)	2.0	%	ISO 527-2/5
Flexural Modulus ¹	8100	MPa	ISO 178
Flexural Stress ²			ISO 178
-- ³	176	MPa	
-- ⁴	177	MPa	
Flexural Strain at Break ⁵	2.9	%	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ⁶ (23°C)	11	kJ/m²	ISO 180/1A
Unnotched Izod Impact Strength ⁷ (23°C)	45	kJ/m²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁸ (1.8 MPa, Unannealed, 64.0 mm Span)	138	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	2.4E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.6E-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.	2.0 mm/min
3.	Break
4.	Yield
5.	2 mm/min
6.	80*10*4
7.	80*10*4
8.	80*10*4 mm

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