

LNP™ LUBRICOMP™ DBL34E compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP DBL34E is a compound based on Polycarbonate resin containing Glass Bead, PTFE. Added features include: Easy Molding, Internally Lubricated.

Also known as: LNP* LUBRICOMP* Compound DBL-4034 LV

Product reorder name: DBL34E

General Information			
Filler / Reinforcement	Glass Bead		
Additive	PTFE Lubricant		
Features	Good Moldability		
	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
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	46.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.9	%	ISO 527-2/5
Flexural Modulus ¹	2600	MPa	ISO 178
Flexural Stress	75.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	5.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	30	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	128	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	7.1E-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.	80*10*4	
3.	80*10*4	
4.	80*10*4 mm	

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