

LNP™ LUBRILOY™ DF204 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRILOY DF204 is a compound based on Polycarbonate resin containing 20% Glass Fiber, Proprietary Lubricant. Added feature of th is grade is: Wear Resistant.

Also known as: LNP* LUBRILOY* Compound DF-20

Product reorder name: DF204

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Lubricant		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.20 to 0.30	%	
Across Flow : 24 hr	0.20 to 0.30	%	
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus ¹	6760	MPa	ASTM D638
Tensile Strength (Break)	105	MPa	ASTM D638
Tensile Elongation (Break)	2.8	%	ASTM D638
Flexural Modulus	6000	MPa	ASTM D790
Flexural Strength	159	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.41		
vs. Itself - Static	0.39		
Wear Factor - Washer	179	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	180	J/m	ASTM D256
Unnotched Izod Impact (23°C)	760	J/m	ASTM D4812
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed, 3.20 mm	142	°C	
1.8 MPa, Unannealed, 3.20 mm	138	°C	
CLTE			ASTM E831
Flow : -40 to 40°C	7.4E-5	cm/cm/°C	

Transverse : -40 to 40°C	6.8E-5	cm/cm/°C	
Thermal Conductivity	0.25	W/m/K	ASTM E1530
Injection	Nominal Value	Unit	
Drying Temperature	100	°C	
Drying Time	4.0	hr	
Suggested Max Moisture	0.020	%	
Rear Temperature	293 to 304	°C	
Middle Temperature	299 to 310	°C	
Front Temperature	304 to 316	°C	
Processing (Melt) Temp	304 to 316	°C	
Mold Temperature	65.6 to 93.3	°C	
Back Pressure	0.172 to 0.344	MPa	
Screw Speed	30 to 60	rpm	
NOTE			
1.	50 mm/min		

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