LNP™ LUBRICOMP™ DBL349E compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DBL349E is a compound based on Polycarbonate resin containing Glass Bead, PTFE, Flame Retardant. Added features of this material include: Internally Lubricated, Flame Retardant.
Also known as: LNP* LUBRICOMP* Compound DBL-4034 EM FR
Product reorder name: DBL349E

General Information			
Filler / Reinforcement	Glass beads		
Additive	PTFE lubricant		
Features	Lubrication Flame retardancy		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.48	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.40 - 0.60	%	ASTM D955
Transverse flow: 24 hours	0.60 - 0.80	%	ASTM D955
Vertical flow direction: 24 hours	0.69	%	ISO 294-4
Flow direction: 24 hours	0.54	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	3450	MPa	ASTM D638
--	2970	MPa	ISO 527-2/1
Tensile Strength			
Yield	41.4	MPa	ASTM D638
Yield	41.0	MPa	ISO 527-2
Fracture	37.9	MPa	ASTM D638
Fracture	38.0	MPa	ISO 527-2
Tensile Elongation			
Yield	2.9	%	ASTM D638, ISO 527-2
Fracture	9.0	%	ASTM D638
Fracture	7.6	%	ISO 527-2
Flexural Modulus			
--	2760	MPa	ASTM D790
--	2900	MPa	ISO 178
Flexural Stress	78.0	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified

With self-dynamics	0.52		ASTM D3702 Modified
With Self-Static	0.70		ASTM D3702 Modified
Wear Factor - Washer	90.5	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	59	J/m	ASTM D256
23°C [2]	5.6	kJ/m²	ISO 180/1A
Unnotched Izod Impact			
23°C	460	J/m	ASTM D4812
23°C [3]	31	kJ/m²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	15.7	J	ASTM D3763
--	4.50	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]	140	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	129	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span [5]	129	°C	ISO 75-2/Af
Linear thermal expansion coefficient			
Flow: -40 to 40°C	6.5E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	6.5E-5	cm/cm/°C	ASTM E831
Lateral: -40 to 40°C	6.4E-5	cm/cm/°C	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	310 - 321	°C	
Front Temperature	321 - 332	°C	
Processing (Melt) Temp	304 - 327	°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		

infringement occurs, please contact us immediately.

Recommended distributors for this material

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