

LNP™ LUBRICOMP™ DFL36EU compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DFL36EU is a compound based on Polycarbonate resin containing 30% Glass Fiber, 15% PTFE. Added features of this material include: Easy Molding , UV Stabilized, Wear Resistant.

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

Product reorder name: DFL36EU

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	PTFE Lubricant (15%)		
	UV Stabilizer		
Features	Good Moldability		
	Good UV Resistance		
	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.56	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.10 to 0.30	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Water Absorption			
24 hr, 50% RH	0.080	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.11	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	9230	MPa	ASTM D638
--	8690	MPa	ISO 527-2/1
Tensile Strength			
Break ²	116	MPa	ASTM D638
Break	113	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.7	%	ASTM D638
Break	2.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	8910	MPa	ASTM D790
-- ⁵	8340	MPa	ISO 178

Flexural Stress			
--	175	MPa	ISO 178
Yield, 50.0 mm Span ⁶	190	MPa	ASTM D790
Break, 50.0 mm Span ⁷	189	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.47		
vs. Itself - Static	0.51		
Wear Factor			ASTM D3702 Modified
Ring	2.00	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	30.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	170	J/m	ASTM D256
23°C ⁸	16	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	710	J/m	ASTM D4812
23°C ⁹	51	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	16.9	J	ASTM D3763
--	5.30	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	146	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ¹⁰	145	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	141	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	141	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	5.4E-5	cm/cm/°C	
Transverse : -30 to 30°C	4.3E-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.	5.0 mm/min		

2.	Type I, 5.0 mm/min
3.	Type I, 5.0 mm/min
4.	1.3 mm/min
5.	2.0 mm/min
6.	1.3 mm/min
7.	1.3 mm/min
8.	80*10*4
9.	80*10*4
10.	80*10*4 mm
11.	80*10*4 mm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

