LNP™ LUBRICOMP™ DFL28 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DFL28 is a compound based on Polycarbonate resin containing Glass Fiber, PTFE. Added features of this material include: Internally Lubricated.
Also known as: LNP* LUBRICOMP* Compound DFL-4028
Product reorder name: DFL28

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Additive	PTFE lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.61	g/cm³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.10 - 0.30	%	ASTM D955
Transverse flow: 24 hours	0.40 - 0.60	%	ASTM D955
Vertical flow direction: 24 hours	0.51	%	ISO 294-4
Flow direction: 24 hours	0.21	%	ISO 294-4
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	13800	MPa	ASTM D638
--	12900	MPa	ISO 527-2/1
Tensile Strength			
Yield	149	MPa	ASTM D638
Yield	145	MPa	ISO 527-2
Fracture	149	MPa	ASTM D638
Fracture	145	MPa	ISO 527-2
Tensile Elongation			ASTM D638, ISO 527-2
Yield	2.2	%	ASTM D638, ISO 527-2
Fracture	2.2	%	ASTM D638, ISO 527-2
Flexural Modulus			
--	11700	MPa	ASTM D790
--	11800	MPa	ISO 178
Flexural Strength			
--	207	MPa	ASTM D790
--	216	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
With self-dynamics	0.53		ASTM D3702 Modified

With Self-Static	0.53		ASTM D3702 Modified
Wear Factor - Washer	129	10^-10 in^5-min/ft-lb-hr	ASTM D3702 Modified
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	160	J/m	ASTM D256
23°C [2]	17	kJ/m²	ISO 180/1A
Unnotched Izod Impact			
23°C	890	J/m	ASTM D4812
23°C [3]	57	kJ/m²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	22.7	J	ASTM D3763
--	5.80	J	ISO 6603-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	145	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span [4]	146	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	140	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span [5]	142	°C	ISO 75-2/Af
Linear thermal expansion coefficient			
Flow: -40 to 40°C	3.2E-5	cm/cm/°C	ASTM E831
Flow: -40 to 40°C	3.3E-5	cm/cm/°C	ISO 11359-2
Lateral: -40 to 40°C	2.7E-5	cm/cm/°C	ASTM E831, 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		

Recommended distributors for this material

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