

LNP™ LUBRILOY™ DF206XXH compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRILOY DF206XXH is a compound based on Polycarbonate containing 30% Glass Fiber, Proprietary Lubricant. Added features of this grade include: Wear Resistant, Healthcare.

Also known as: LNP* LUBRILOY* Compound DF-30 HC

Product reorder name: DF206XXH

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Additive	Lubricant		
Features	Good Wear Resistance		
	Lubricated		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.40	g/cm ³	
--	1.39	g/cm ³	
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.40 to 0.60	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Water Absorption			
24 hr, 50% RH	0.11	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.16	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	8730	MPa	ASTM D638
--	8250	MPa	ISO 527-2/1
Tensile Strength			
Break ²	112	MPa	ASTM D638
Break	112	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	2.6	%	ASTM D638
Break	2.6	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	7830	MPa	ASTM D790
-- ⁵	7590	MPa	ISO 178
Flexural Stress			

--	166	MPa	ISO 178
Yield, 50.0 mm Span ⁶	174	MPa	ASTM D790
Break, 50.0 mm Span ⁷	169	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.49		
vs. Itself - Static	0.64		
Wear Factor			ASTM D3702 Modified
Ring	27.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	245	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	180	J/m	ASTM D256
23°C ⁸	18	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	780	J/m	ASTM D4812
23°C ⁹	49	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	26.1	J	ASTM D3763
--	6.50	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	142	°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	5.6E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.1E-5	cm/cm/°C	
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.	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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