

LNP™ LUBRICOMP™ DFL23 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DFL23 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-4023

Product reorder name: DFL23

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	1.38	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.30 - 0.50	%	ASTM D955
Transverse flow: 24 hours	0.50 - 0.70	%	ASTM D955
Vertical flow direction: 24 hours	0.60	%	ISO 294-4
Flow direction: 24 hours	0.38	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	5520	MPa	ASTM D638
--	5330	MPa	ISO 527-2/1
Tensile Strength			
Yield	88.9	MPa	ASTM D638
Yield	88.0	MPa	ISO 527-2
Fracture	67.6	MPa	ASTM D638
Fracture	88.0	MPa	ISO 527-2
Tensile Elongation			
Yield	3.1	%	ASTM D638
Yield	3.0	%	ISO 527-2
Fracture	3.5	%	ASTM D638
Fracture	3.1	%	ISO 527-2
Flexural Modulus			
--	4830	MPa	ASTM D790
--	5100	MPa	ISO 178
Flexural Strength			
--	138	MPa	ASTM D790

--	142	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
With self-dynamics	0.50		ASTM D3702 Modified
With Self-Static	0.55		ASTM D3702 Modified
Wear Factor - Washer	163	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	150	J/m	ASTM D256
23°C ²	13	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	760	J/m	ASTM D4812
23°C ³	44	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	23.3	J	ASTM D3763
--	7.60	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	145	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	140	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ⁵	141	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	4.7E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	4.3E-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		

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