

LNP™ STAT-KON™ DEL329E compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP STAT-KON DEL329E is a compound based on Polycarbonate resin containing PTFE, Flame Retardant, Carbon Fiber. Added features of this material include: Electrically Conductive, Flame Retardant, Internally Lubricated.

Also known as: LNP* STAT-KON* Compound DCL-4032 EM FR

Product reorder name: DEL329E

General Information			
Filler / Reinforcement	Carbon fiber reinforced material		
Additive	PTFE lubricant		
Features	Conductivity		
	Lubrication		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
--	1.40	g/cm ³	ASTM D792
--	1.37	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.20 - 0.50	%	ASTM D955
Transverse flow: 24 hours	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	7370	MPa	ASTM D638
--	7110	MPa	ISO 527-2/1
Tensile Strength			
Fracture ²	95.0	MPa	ASTM D638
Fracture	93.0	MPa	ISO 527-2/5
Tensile Elongation			
Fracture ³	2.3	%	ASTM D638
Fracture	2.3	%	ISO 527-2/5
Flexural Modulus			
50.0mm span ⁴	6320	MPa	ASTM D790
-- ⁵	6540	MPa	ISO 178
Flexural Stress			
--	140	MPa	ISO 178
Yield, 50.0mm span ⁶	143	MPa	ASTM D790
Fracture, 50.0mm span ⁷	141	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	63	J/m	ASTM D256
23°C ⁸	6.2	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	400	J/m	ASTM D4812
23°C ⁹	23	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	17.0	J	ASTM D3763
--	3.70	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, unannealed, 3.20mm	149	°C	ASTM D648
0.45 MPa, unannealed, 64.0mm span ¹⁰	148	°C	ISO 75-2/Bf
1.8 MPa, unannealed, 3.20mm	146	°C	ASTM D648
1.8 MPa, unannealed, 64.0mm span ¹¹	145	°C	ISO 75-2/Af
Linear thermal expansion coefficient			ASTM D696
Flow: -30 to 30°C	2.5E-5	cm/cm/°C	ASTM D696
Lateral: -30 to 30°C	7.3E-5	cm/cm/°C	ASTM D696
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0 - 6.0	ohms	ASTM D257
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.	5.0 mm/min		
2.	Type 1, 5.0 mm/min		
3.	Type 1, 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

