

LNP™ LUBRICOMP™ DI001E compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP DI001E is a compound based on Polycarbonate resin containing Silicone. Added features include: Internally Lubricated, Easy Molding.

General Information			
Additive	Silicone Lubricant		
Features	Good Moldability		
	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2200	MPa	ISO 527-2/1
Tensile Stress (Yield)	57.0	MPa	ISO 527-2/5
Tensile Strain (Yield)	5.5	%	ISO 527-2/5
Flexural Modulus ¹	2100	MPa	ISO 178
Flexural Stress	88.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	40	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	170	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴			
0.45 MPa, Unannealed, 64.0 mm Span	137	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 64.0 mm Span	124	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : 23 to 60°C	7.2E-5	cm/cm/°C	
Transverse : 23 to 60°C	7.2E-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	304 to 316	°C	
Front Temperature	310 to 321	°C	
Processing (Melt) Temp	299 to 316	°C	
Mold Temperature	82.2 to 110	°C	

Back Pressure	0.172 to 0.344	MPa
Screw Speed	30 to 60	rpm
NOTE		
1.	2.0 mm/min	
2.	80*10*4	
3.	80*10*4	
4.	80*10*4 mm	

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