

LNP™ LUBRICOMP™ DCP36 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DCP36 is a compound based on Polycarbonate containing 30% Carbon Fiber, 15% PTFE/Silicone. Added features of this grade include: Wear Resistant, Electrically Conductive.

Also known as: LNP* LUBRICOMP* Compound DCL-4536

Product reorder name: DCP36

General Information			
Filler / Reinforcement	Carbon Fiber,30% Filler by Weight		
Additive	PTFE + Silicone Lubricant (15%)		
Features	Electrically Conductive		
	Good Wear Resistance		
	Lubricated		
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	0.17	%	
Across Flow : 24 hr	0.30	%	
Water Absorption			
24 hr, 50% RH	0.050	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.10	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	16300	MPa	ASTM D638
--	15300	MPa	ISO 527-2/1
Tensile Strength			
Break ²	111	MPa	ASTM D638
Break	120	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	1.2	%	ASTM D638
Break	1.7	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁴	13400	MPa	ASTM D790
-- ⁵	13800	MPa	ISO 178
Flexural Stress			

--	183	MPa	ISO 178
Yield, 50.0 mm Span ⁶	186	MPa	ASTM D790
Break, 50.0 mm Span ⁷	185	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.50		
vs. Itself - Static	0.48		
Wear Factor			ASTM D3702 Modified
Ring	0.650	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Washer	18.0	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	91	J/m	ASTM D256
23°C ⁸	8.7	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	460	J/m	ASTM D4812
23°C ⁹	23	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	13.8	J	ASTM D3763
--	3.90	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	140	°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	137	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹¹	140	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	5.0E-6	cm/cm/°C	
Transverse : -30 to 30°C	3.1E-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	310 to 321	°C	
Front Temperature	321 to 332	°C	
Processing (Melt) Temp	304 to 327	°C	
Mold Temperature	82.2 to 110	°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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