LNP™ LUBRICOMP™ DFL24 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DFL24 is a compound based on Polycarbonate resin containing 20% Glass Fiber, 10% PTFE. Added feature of this material is: Wear Resistant.
Also known as: LNP* LUBRICOMP* Compound DFL-4024
Product reorder name: DFL24

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	PTFE Lubricant (10%)		
Features	Good Wear Resistance Lubricated		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Specific Gravity	1.41	g/cm³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.30 to 0.50	%	
Across Flow : 24 hr	0.50 to 0.70	%	
Water Absorption			
24 hr, 50% RH	0.080	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.13	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			
-- [1]	5710	MPa	ASTM D638
--	5610	MPa	ISO 527-2/1
Tensile Strength			
Yield [2]	87.0	MPa	ASTM D638
Yield	86.0	MPa	ISO 527-2/5
Break [3]	86.0	MPa	ASTM D638
Break	85.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield [4]	3.2	%	ASTM D638
Yield	3.0	%	ISO 527-2/5
Break [5]	3.6	%	ASTM D638
Break	3.4	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span [6]	5500	MPa	ASTM D790
-- [7]	5140	MPa	ISO 178

Flexural Stress			
--	136	MPa	ISO 178
Yield, 50.0 mm Span [8]	5.00	MPa	ASTM D790
Break, 50.0 mm Span [9]	6.00	MPa	ASTM D790
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.42		
vs. Itself - Static	0.54		
Wear Factor			ASTM D3702 Modified
Ring	5.20	10^-10 in^5-min/ft-lb-hr	
Washer	138	10^-10 in^5-min/ft-lb-hr	
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact			
23°C	150	J/m	ASTM D256
23°C [10]	13	kJ/m²	ISO 180/1A
Unnotched Izod Impact			
23°C	720	J/m	ASTM D4812
23°C [11]	43	kJ/m²	ISO 180/1U
Instrumented Dart Impact			
23°C, Total Energy	22.7	J	ASTM D3763
--	6.76	J	ISO 6603-2
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	147	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span [12]	146	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	143	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span [13]	141	°C	ISO 75-2/Af
CLTE			ASTM D696
Flow : -30 to 30°C	3.7E-5	cm/cm/°C	
Transverse : -30 to 30°C	5.3E-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.	Type I, 5.0 mm/min
5.	Type I, 5.0 mm/min
6.	1.3 mm/min
7.	2.0 mm/min
8.	1.3 mm/min
9.	1.3 mm/min
10.	80*10*4
11.	80*10*4
12.	80*10*4 mm
13.	80*10*4 mm

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