

LNP™ LUBRICOMP™ DCL33E compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP LUBRICOMP DCL33E is a compound based on Polycarbonate resin containing Carbon Fiber, PTFE. Added features include; Internally Lubricated, Electrically Conductive, Easy Molding.

Also known as: LNP* LUBRICOMP* Compound DCL4033

Product reorder name: DCL33E

General Information			
UL YellowCard	E45329-101343782		
Filler / Reinforcement	Carbon Fiber		
Additive	PTFE Lubricant		
Features	Electrically Conductive		
	Good Moldability		
	Lubricated		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.35	g/cm ³	ISO 1183
Molding Shrinkage - Flow	0.15 to 0.30	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Break)	121	MPa	ISO 527-2/5
Tensile Strain (Break)	1.8	%	ISO 527-2/5
Flexural Modulus ¹	11900	MPa	ISO 178
Flexural Stress	177	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ² (23°C)	6.0	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength ³ (23°C)	25	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ⁴ (1.8 MPa, Unannealed, 64.0 mm Span)	139	°C	ISO 75-2/Af
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+2 to 1.0E+4	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (4.50 mm)	V-0		UL 94
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. | 2.0 mm/min |
| 2. | 80*10*4 |
| 3. | 80*10*4 |
| 4. | 80*10*4 mm |

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