

LNP™ LUBRICOMP™ DX96651 compound

Polycarbonate
SABIC Innovative Plastics

Message:

LNP LUBRICOMP* DX96651 is a compound based on Polycarbonate resin containing Proprietary Filler(s). Added features of this material include: Internally Lubricated.
Also known as: LNP* LUBRICOMP* Compound PDX-D-96651 SF
Product reorder name: DX96651

General Information			
Filler / Reinforcement	Proprietary packing		
Additive	Lubricant		
Features	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.23	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow: 24 hours	0.70	%	ASTM D955
Transverse flow: 24 hours	0.70	%	ASTM D955
Vertical flow direction: 24 hours	0.75	%	ISO 294-4
Flow direction: 24 hours	0.73	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.16	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2210	MPa	ASTM D638
--	2400	MPa	ISO 527-2/1
Tensile Strength			
Yield	48.5	MPa	ASTM D638
Yield	55.0	MPa	ISO 527-2
Fracture	58.6	MPa	ASTM D638
Fracture	46.8	MPa	ISO 527-2
Flexural Modulus			
--	2480	MPa	ASTM D790
--	2600	MPa	ISO 178
Flexural Strength			
--	93.5	MPa	ASTM D790
--	90.7	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	100	J/m	ASTM D256
23°C ²	9.2	kJ/m ²	ISO 180/1A

Unnotched Izod Impact			
23°C	No Break		ASTM D4812
23°C ³	140	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	41.0	J	ASTM D3763
--	128	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 3.20mm	140	°C	ASTM D648
1.8 MPa, unannealed, 3.20mm	128	°C	ASTM D648
Linear thermal expansion coefficient			ASTM E831, ISO 11359-2
Flow: -40 to 40°C	6.6E-5	cm/cm/°C	ASTM E831, ISO 11359-2
Lateral: -40 to 40°C	6.6E-5	cm/cm/°C	ASTM E831, ISO 11359-2
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	304 - 316	°C	
Front Temperature	310 - 321	°C	
Processing (Melt) Temp	299 - 316	°C	
Mold Temperature	82.2 - 110	°C	
Back Pressure	0.172 - 0.344	MPa	
Screw Speed	30 - 60	rpm	
NOTE			
1.	50 mm/min		
2.	80*10*4		
3.	80*10*4		

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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



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