

LNP™ LUBRICOMP™ DFL36E compound

Polycarbonate

SABIC Innovative Plastics Europe

Message:

LNP* LUBRICOMP* DFL36E is a compound based on Polycarbonate resin containing 30% Glass Fiber, 15% PTFE. Added features of this material include: Easy Molding, Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound DFL-4036 EM

Product reorder name: DFL36E

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Additive	PTFE lubricant (15%)		
Features	Good formability		
	Good wear resistance		
	Lubrication		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.57	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow: 24 hours	0.20	%	ASTM D955
Transverse flow: 24 hours	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			ASTM D638
Fracture	123	MPa	ASTM D638
Fracture ¹	123	MPa	ASTM D638
Tensile Elongation			ASTM D638
Fracture	2.4	%	ASTM D638
Fracture ²	2.4	%	ASTM D638
Flexural Modulus			ASTM D790
50.0mm span ³	9380	MPa	ASTM D790
--	9380	MPa	ASTM D790
Flexural Strength			ASTM D790
--	188	MPa	ASTM D790
Fracture, 50.0mm span ⁴	188	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	150	J/m	ASTM D256
Unnotched Izod Impact (23°C)	690	J/m	ASTM D4812
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	310 - 321	°C
Front Temperature	321 - 332	°C
Processing (Melt) Temp	304 - 327	°C
Mold Temperature	82.2 - 110	°C
Back Pressure	0.172 - 0.344	MPa
Screw Speed	30 - 60	rpm

NOTE

- | | |
|----|--------------------|
| 1. | Type 1, 5.0 mm/min |
| 2. | Type 1, 5.0 mm/min |
| 3. | 1.3 mm/min |
| 4. | 1.3 mm/min |

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