

LNP™ LUBRICOMP™ DX09407H compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP LUBRICOMP DX09407H is a compound based on High Heat Polycarbonate containing proprietary fillers. Added features of this grade are: Wear Resistant, Healthcare.

Also known as: LNP* LUBRICOMP* Compound DX09407H

Product reorder name: DX09407H

General Information			
Filler / Reinforcement	Proprietary		
Features	Good Wear Resistance		
	High Heat Resistance		
Uses	Medical/Healthcare Applications		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.21	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 24 hr	0.50 to 0.70	%	
Across Flow : 24 hr	0.60 to 0.80	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	0.21	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	2230	MPa	ASTM D638
--	2130	MPa	ISO 527-2/1
Tensile Strength			
Yield ²	64.0	MPa	ASTM D638
Yield	64.0	MPa	ISO 527-2/5
Break ³	53.0	MPa	ASTM D638
Break	56.0	MPa	ISO 527-2/5
Tensile Elongation			
Yield ⁴	6.8	%	ASTM D638
Yield	6.9	%	ISO 527-2/5
Break ⁵	68	%	ASTM D638
Break	110	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span ⁶	2310	MPa	ASTM D790
-- ⁷	2080	MPa	ISO 178
Flexural Strength ⁸ (Break, 50.0 mm Span)	90.0	MPa	ASTM D790

Flexural Strain at Break ⁹	77	%	ISO 178
Coefficient of Linear Thermal Expansion - Flow (-30 to 100°C)	7.40E-5	µm/Mk	ISO 11359-2
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	140	J/m	ASTM D256
23°C ¹⁰	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	2200	J/m	ASTM D4812
23°C ¹¹	190	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed, 3.20 mm	139	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ¹²	137	°C	ISO 75-2/Af
CLTE			ISO 11359-2
Flow : -40 to 40°C	7.4E-5	cm/cm/°C	
Transverse : -40 to 40°C	7.7E-5	cm/cm/°C	
Injection	Nominal Value	Unit	
Drying Temperature	121	°C	
Drying Time	3.0 to 4.0	hr	
Drying Time, Maximum	48	hr	
Suggested Max Moisture	0.020	%	
Suggested Shot Size	40 to 60	%	
Rear Temperature	271 to 293	°C	
Middle Temperature	282 to 304	°C	
Front Temperature	293 to 316	°C	
Nozzle Temperature	288 to 310	°C	
Processing (Melt) Temp	293 to 316	°C	
Mold Temperature	71.1 to 93.3	°C	
Back Pressure	0.345 to 0.689	MPa	
Screw Speed	40 to 70	rpm	
Vent Depth	0.025 to 0.076	mm	
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.	2 mm/min		

10.	80*10*4
11.	80*10*4
12.	80*10*4 mm

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