

LNP™ LUBRICOMP™ DFP34 compound

Polycarbonate

SABIC Innovative Plastics

Message:

LNP* LUBRICOMP* DFP34 is a compound based on Polycarbonate resin containing 20% Glass Fiber, 15% PTFE/Silicone. Added feature of this material is: Wear Resistant.

Also known as: LNP* LUBRICOMP* Compound DFL-4534

Product reorder name: DFP34

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	PTFE + Silicone Lubricant (15%)		
Features	Good Wear Resistance		
	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.42	g/cm ³	ASTM D792, ISO 1183
Molding Shrinkage			
Flow : 24 hr	0.30 to 0.50	%	ASTM D955
Across Flow : 24 hr	0.30 to 0.50	%	ASTM D955
Across Flow : 24 hr	0.44	%	ISO 294-4
Flow : 24 hr	0.36	%	ISO 294-4
Water Absorption (24 hr, 50% RH)	0.10	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
-- ¹	6890	MPa	ASTM D638
--	6740	MPa	ISO 527-2/1
Tensile Strength			
Yield	103	MPa	ASTM D638, ISO 527-2
Break	103	MPa	ASTM D638
Break	104	MPa	ISO 527-2
Tensile Elongation			
Yield	2.8	%	ASTM D638
Yield	2.5	%	ISO 527-2
Break	2.8	%	ASTM D638
Break	2.5	%	ISO 527-2
Flexural Modulus			
--	6210	MPa	ASTM D790
--	6400	MPa	ISO 178
Flexural Strength			

--	159	MPa	ASTM D790
--	158	MPa	ISO 178
Coefficient of Friction			ASTM D3702 Modified
vs. Itself - Dynamic	0.51		
vs. Itself - Static	0.53		
Wear Factor - Washer	108	10 ⁻¹⁰ in ⁵ -min/ft-lb-hr	ASTM D3702 Modified
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	140	J/m	ASTM D256
23°C ²	14	kJ/m ²	ISO 180/1A
Unnotched Izod Impact			
23°C	720	J/m	ASTM D4812
23°C ³	44	kJ/m ²	ISO 180/1U
Instrumented Dart Impact			
23°C, Energy at Peak Load	24.9	J	ASTM D3763
--	6.30	J	ISO 6603-2
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed, 3.20 mm	144	°C	ASTM D648
0.45 MPa, Unannealed, 64.0 mm Span ⁴	145	°C	ISO 75-2/Bf
1.8 MPa, Unannealed, 3.20 mm	141	°C	ASTM D648
1.8 MPa, Unannealed, 64.0 mm Span ⁵	141	°C	ISO 75-2/Af
CLTE			ASTM E831, ISO 11359-2
Flow : -40 to 40°C	4.7E-5	cm/cm/°C	
Transverse : -40 to 40°C	3.6E-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.	50 mm/min		
2.	80*10*4		
3.	80*10*4		
4.	80*10*4 mm		
5.	80*10*4 mm		

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